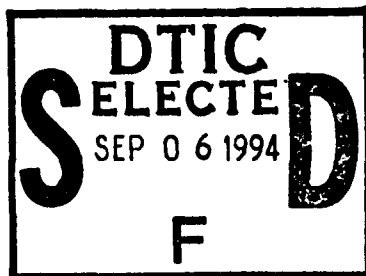


AD-A284 013



NOT MEASUREMENT  
SENSITIVE

MIL-STD-105E  
10 MAY 1989

SUPERSEDING  
MIL-STD-105D  
29 APRIL 1963

# MILITARY STANDARD

SAMPLING PROCEDURES AND TABLES  
FOR INSPECTION BY ATTRIBUTES



94-28736



7/6/86

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**SAMPLING PROCEDURES AND TABLES FOR INSPECTION BY ATTRIBUTES**

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by using the self-addressed Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or letter.

FOREWORD

This publication provides sampling procedures and reference tables for use in planning and conducting inspection by attributes. The sampling concept is based on the probabilistic recurrence of events when a series of lots or batches are produced in a stable environment.

This publication should be used to guide the user in the development of an inspection strategy that provides a cost effective approach to attaining confidence in product compliance with contractual technical requirements. The user is warned of the assumed risks relative to the chosen sample size and AQL.

Military specifications should not contain requirements for use of specific sampling plans, nor should they provide AQL's or LTPD's as a requirement.

Sampling plans for continuous, rather than lot inspection, are contained in MIL-STD-1235, "Single and Multi-Level Continuous Sampling Procedures and Tables for Inspection by Attributes".

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SAMPLING PROCEDURES AND TABLES  
FOR INSPECTION BY ATTRIBUTES

## 1. SCOPE

1.1 Purpose. This publication establishes lot or batch sampling plans and procedures for inspection by attributes. This publication shall not be interpreted to supercede or conflict with any contractual requirements. The words "accept", "acceptance", "acceptable", etc, refer only to the contractor's use of the sampling plans contained in this standard and do not imply an agreement by the Government to accept any product. Determination of acceptability by the Government shall be as described in contractual documents. The sampling plans described in this standard are applicable to AQL's of .01 percent or higher and are therefore not suitable for applications where quality levels in the defective parts per million range can be realized.

1.2 Application. Sampling plans designated in this publication are applicable, but not limited, to inspection of the following:

- a. End items.
- b. Components and raw materials.
- c. Operations or services.
- d. Materials in process.
- e. Supplies in storage.
- f. Maintenance operations.
- g. Data or records.
- h. Administrative procedures.

These plans are intended primarily to be used for a continuing series of lots or batches. The plans may also be used for the inspection of isolated lots or batches, but, in this latter case, the user is cautioned to consult the operating characteristic curves to find a plan which will yield the desired protection (See 4.11).

## 2. REFERENCED DOCUMENTS

2.1 Not applicable.

## 3. DEFINITIONS



3.1 Acceptable Quality Level (AQL). When a continuous series of lots is considered, the AQL is the quality level which, for the purposes of sampling inspection, is the limit of a satisfactory process average (See 3.19).

NOTE: A sampling plan and an AQL are chosen in accordance with the risk assumed. Use of a value of AQL for a certain defect or group of defects indicates that the sampling plan will accept the great majority of the lots or batches provided the process average level of percent defective (or defects per hundred units) in these lots or batches be no greater than the designated value of AQL. Thus, the AQL is a designated value of percent defective (or defects per hundred units) for which lots will be accepted most of the time by the sampling procedure being used. The sampling plans provided herein are so arranged that the probability of acceptance at the designated AQL value depends upon the sample size, being generally higher for large samples than for small ones, for a given AQL. The AQL alone does not identify the chances of accepting or rejecting individual lots or batches but more directly relates to what might be expected from a series of lots or batches, provided the steps indicated in this publication are taken. It is necessary to refer to the operating characteristic curve of the plan to determine the relative risks.

3.2 Average Outgoing Quality (AOQ). For a particular process average, the AOQ is the average quality of outgoing product including all accepted lots or batches, plus all rejected lots or batches after the rejected lots or batches have been effectively 100 percent inspected and all defectives replaced by non-defectives.

3.3 Average Outgoing Quality Limit (AOQL). The AOQL is the maximum AOQ for a given acceptance sampling plan. Factors for computing AOQL values are given in Table V-A for each of the single sampling plans for normal inspection and in Table V-B for each of the single sampling plans for tightened inspection.

3.4 Classification of Defects. A classification of defects is the enumeration of possible defects of the unit of product classified according to their seriousness.

3.5 Critical Defect. A critical defect is a defect that judgement and experience indicate would result in hazardous or unsafe conditions for individuals using, maintaining, or depending upon the product, or a defect that judgement and experience indicate is likely to prevent performance of the tactical function of a major end item such as a ship, aircraft, tank, missile, or space vehicle.

3.6 Critical Defective. A critical defective is a unit of product which contains one or more critical defects and may also contain major and/or minor defects.

3.7 Defect. A defect is any nonconformance of the unit of product with specified requirements.

3.8 Defective. A defective is a unit of product which contains one or more defects.

3.9 Defects per Hundred Units. The number of defects per hundred units of any given quantity of units of product is one hundred times the number of defects contained therein (one or more defects being possible in any unit of product) divided by the total number of units of product, i.e.:

$$\text{Defects per hundred units} = \frac{\text{Number of defects} \times 100}{\text{Number of units inspected}}$$

3.10 Inspection. Inspection is the process of measuring, examining, testing, or otherwise comparing the unit of product with the requirements.

3.11 Inspection by Attributes. Inspection by attributes is inspection whereby either the unit of product is classified simply as defective or non-defective, or the number of defects in the unit of product is counted, with respect to a given requirement or set of requirements.

3.12 Lot or Batch. The term lot or batch shall mean "inspection lot" or "inspection batch", i.e., a collection of units of product from which a sample is to be drawn and inspected and may differ from a collection of units designated as a lot or batch for other purposes (e.g., production, shipment, etc.).

3.13 Lot or Batch Size. The lot or batch size is the number of units of product in a lot or batch.

3.14 Major Defect. A major defect is a defect, other than critical, that is likely to result in failure, or to reduce materially the usability of the unit of product for its intended purpose.

3.15 Major Defective. A major defective is a unit of product which contains one or more major defects, and may also contain minor defects but contains no critical defect.

3.16 Minor Defect. A minor defect is a defect that is not likely to reduce materially the usability of the unit of product for its intended purpose, or is a departure from established standards having little bearing on the effective use or operation of the unit.

3.17 Minor Defective. A minor defective is a unit of product which contains one or more minor defects but contains no critical or major defect.

3.18 Percent Defective. The percent defective of any given quantity of units of product is one hundred times the number of defective units of product contained therein divided by the total number of units of product, i.e.:

$$\text{Percent Defective} = \frac{\text{Number of defectives} \times 100}{\text{Number of units inspected}}$$

3.19 Process Average. The process average is the average percent defective or average number of defects per hundred units (whichever is applicable) of product submitted by the supplier for original inspection. Original inspection is the first inspection of a particular quantity of product as distinguished from the inspection of product which has been resubmitted after prior rejection.

3.20 Sample. A sample consists of one or more units of product drawn from a lot or batch, the units of the sample being selected at random without regard to their quality. The number of units of product in the sample is the sample size.

3.21 Sample Size Code Letter. The sample size code letter is a device used along with the AQL for locating a sampling plan on a table of sampling plans.

3.22 Sampling Plan. A sampling plan indicates the number of units of product from each lot or batch which are to be inspected (sample size or series of sample sizes) and the criteria for determining the acceptability of the lot or batch (acceptance and rejection numbers).

3.23 Unit of Product. The unit of product is the thing inspected in order to determine its classification as defective or non-defective or to count the number of defects. It may be a single article, a pair, a set, a length, an area, an operation, a volume, a component of an end product, or the end product itself. The unit of product may or may not be the same as the unit of purchase, supply, production, or shipment.

#### 4. GENERAL REQUIREMENTS

4.1 Written Procedures. Written procedures are ordinarily developed and made available for the Government representative's review, upon request. When the written procedures indicate use of this standard, they shall comply with the requirements of this standard and reference appropriate parts as necessary.

4.2 Nonconformance. The extent of nonconformance of product shall be expressed either in terms of percent defective or in terms of defects per hundred units.

4.3 Formation and Identification of Lots or Batches. The product shall be assembled into identifiable lots, sublots, batches, or in such other manner as may be prescribed. Each lot or batch shall, as far as is practicable, consist of units of product of a single type, grade, class, size, and composition, manufactured under essentially the same conditions, and at essentially the same time. The lots or batches shall be identified by the contractor and shall be kept intact in adequate and suitable storage space.

#### 4.4 AQL.

4.4.1 AQL Use. The AQL, together with the Sample Size Code Letter, is used for indexing the sampling plans provided herein.

4.4.2 Limitation. The selection or use of an AQL shall not imply that the contractor has the right to supply any defective unit of product.

4.4.3 Choosing AQLs. Different AQLs may be chosen for groups of defects considered collectively, or for individual defects. An AQL for a group of defects may be chosen in addition to AQLs for individual defects, or subgroups, within that group. AQL values of 10.0 or less may be expressed either in percent defective or in defects per hundred units; those over 10.0 shall be expressed in defects per hundred units only.

#### 4.5 Sampling.

4.5.1 Representative (Stratified) Sampling. When appropriate, the number of units in the sample shall be selected in proportion to the size of sublots or sub-batches, or parts of the lot or batch, identified by some rational criterion. When representative sampling is used, the units from each subplot, sub-batch or part of the lot or batch shall be selected at random.

4.5.2 Time of Sampling. A sample may be drawn after all the units comprising the lot or batch have been assembled, or sample units may be drawn during assembly of the lot or batch, in which case the size of the lot or batch will be determined before any sample units are drawn. If the sample units are drawn during assembly of the lot or batch, and if the rejection number is reached before the lot is completed, that portion of the lot already completed shall be rejected. The cause of the defective product shall be determined and corrective action taken, after which a new lot or batch shall be begun.

4.5.3 Double or Multiple Sampling. When double or multiple sampling is to be used, each sample shall be selected over the entire lot or batch.

4.6 Inspection Procedures. Normal inspection will be used at the start of inspection. Normal, tightened or reduced inspection shall continue unchanged for each class of defects or defectives on successive lots or batches except where the switching procedures given below require change. The switching procedures shall be applied to each class of defects or defectives independently.

4.7 Switching Procedures.

4.7.1 Normal to Tightened. When normal inspection is in effect, tightened inspection shall be instituted when 2 out of 2, 3, 4, or 5 consecutive lots or batches have been rejected on original inspection (i.e., ignoring resubmitted lots or batches for this procedure).

4.7.2 Tightened to Normal. When tightened inspection is in effect, normal inspection shall be instituted when 5 consecutive lots or batches have been considered acceptable on original inspection.

4.7.3 Normal to Reduced. When normal inspection is in effect, reduced inspection shall be instituted provided that all of the following conditions are satisfied:

a. The preceding 10 lots or batches (or more, as indicated by the note to Table VIII) have been on normal inspection and all have been accepted on original inspection; and

b. The total number of defectives (or defects) in the samples from the preceding 10 lots or batches (or such other number as was used for condition "a" above) is equal to or less than the applicable number given in Table VIII. If double or multiple sampling is in use, all samples inspected should be included, not "first" samples only; and

c. Production is at a steady rate; and

d. Reduced inspection is considered desirable.

4.7.4 Reduced to Normal. When reduced inspection is in effect, normal inspection shall be instituted if any of the following occur on original inspection:

a. A lot or batch is rejected; or

b. A lot or batch is considered acceptable under the procedures of 4.10.1.4, or

c. Production becomes irregular or delayed; or

d. Other conditions warrant that normal inspection shall be instituted.

4.8 Discontinuation of Inspection. If the cumulative number of lots not accepted in a sequence of consecutive lots on original tightened inspection reaches five, the acceptance procedures of this standard shall be discontinued. Inspection under the provisions of this standard shall not be resumed until corrective action has been taken. Tightened inspection shall then be used as if 4.7.1 had been invoked.

4.9 Sampling Plans.

4.9.1 Inspection Level. The inspection level determines the relationship between the lot or batch size and the sample size. The inspection level to be used for any particular requirement will be as prescribed by the contractor's written procedures. Three inspection levels: I, II, and III, are given in Table I for general use (see 4.1). Normally, Inspection Level II is used. However, Inspection Level I may be used when less discrimination is needed, or Level III may be used for greater discrimination. Four additional special levels: S-1, S-2, S-3, and S-4, are given in the same table and may be used where relatively small sample sizes are necessary and large sampling risks can or must be tolerated.

NOTE: In the selection of inspection levels S-1 to S-4, care must be exercised to avoid AQLs inconsistent with these inspection levels. In other words, the purpose of the special inspection levels is to keep samples small when necessary. For instance, the code letters under S-1 go no further than D, equivalent to a single sample of size 8, but it is of no use to choose S-1 if the AQL is 0.10 percent for which the minimum sample is 125.

4.9.2 Code Letters. Sample sizes are designated by code letters. Table I shall be used to find the applicable code letter for the particular lot or batch size and the prescribed inspection level.

4.9.3 Obtaining Sampling Plan. The AQL and the code letter shall be used to obtain the sampling plan from Tables II, III, or IV. When no sampling plan is available for a given combination of AQL and code letter, the tables direct the user to a different letter. The sample size to be used is given by the new code letter, not by the original letter. If this procedure leads to different sample sizes for different classes of defects, the code letter corresponding to the largest sample size derived may be used for all classes of defects. As an alternative to a single sampling plan with an acceptance number of 0, the plan with an acceptance number of 1 with its correspondingly larger sample size for a designated AQL (where available), may be used.

4.9.4 Types of Sampling Plans. Three types of sampling plans: Single, Double, and Multiple, are given in Tables II, III, and IV, respectively. When several types of plans are available for a given AQL and code letter, any one may be used. A decision as to type of plan, either single, double, or multiple, when available for a given AQL and code letter, will usually be based upon the comparison between the administrative difficulty and the average sample sizes of the available plans. The average sample size of multiple plans is less than for double (except in the case corresponding to single acceptance number 1) and both of these are always less than a single sample size (see Table IX). Usually the administrative difficulty for single sampling and the cost per unit of the sample are less than for double or multiple.

#### 4.10 Determination of Acceptability.

4.10.1 Percent Defective Inspection. To determine acceptability of a lot or batch under percent defective inspection, the applicable sampling plan shall be used in accordance with 4.10.1.1, 4.10.1.2, 4.10.1.3, and 4.10.1.4.

4.10.1.1 Single Sampling Plan. The number of sample units inspected shall be equal to the sample size given by the plan. If the number of defectives found in the sample is equal to or less than the acceptance number, the lot or batch shall be considered acceptable. If the number of defectives is equal to or greater than the rejection number, the lot or batch shall be rejected.

4.10.1.2 Double Sampling Plan. A number of sample units equal to the first sample size given by the plan shall be inspected. If the number of defectives found in the first sample is equal to or less than the first acceptance number, the lot or batch shall be considered acceptable. If the number of defectives found in the first sample is equal to or greater than the first rejection number, the lot or batch shall be rejected. If the number of defectives found in the first sample is between the first acceptance and rejection numbers, a second sample of the same size shall be inspected. The number of defectives found in the first and second samples shall be accumulated. If the cumulative number of defectives is equal to or less than the second acceptance number, the lot or batch shall be considered acceptable. If the cumulative number of defectives is equal to or greater than the second rejection number, the lot or batch shall be rejected.

4.10.1.3 Multiple Sample Plan. Under multiple sampling, the procedure shall be similar to that specified in 4.10.1.2, except that the number of successive samples required to reach a decision may be as many as seven.

4.10.1.4 Special Procedure for Reduced Inspection. Under reduced inspection, the sampling procedure may terminate without either acceptance or rejection criteria having been met. In these circumstances, the lot or batch will be considered acceptable, but normal inspection will be reinstated starting with the next lot or batch (see 4.7.4.b).

4.10.2 Defects per Hundred Units Inspection. To determine the acceptability of a lot or batch under defects per hundred units inspection, the procedure specified for percent defective inspection above shall be used, except that the word "defects" shall be substituted for "defectives".

4.11 Limiting Quality Protection. The sampling plans and associated procedures given in this publication were designed for use where the units of product are produced in a continuing series of lots or batches over a period of time. However, if the lot or batch is of an isolated nature, it is desirable to limit the selection of sampling plans to those, associated with a designated AQL value, that provide not less than a specified limiting quality protection. Sampling plans for this purpose can be selected by choosing a Limiting Quality (LQ) and a consumer's risk to be associated with it. Tables VI and VII give values of LQ for the commonly used consumer's risks of 10 percent and 5 percent respectively. If a different value of consumer's risk is required, the O.C. curves and their tabulated values may be used. The concept of LQ may also be useful in specifying the AQL and Inspection Levels for a series of lots or batches, thus fixing minimum sample size where there is some reason for avoiding (with more than a given consumer's risk) more than a limiting proportion of defectives (or defects) in any single lot or batch.

#### 4.12 Curves.

4.12.1 Operating Characteristic Curves. The operating characteristic curves for normal inspection, shown in Table X, indicate the percentage of lots or batches which may be expected to be accepted under the various sampling plans for a given process quality. The curves shown are for single sampling; curves for double and multiple sampling are matched as closely as practicable. The O.C. curves shown for AQLs greater than 10.0 are based on the Poisson distribution and are applicable for defects per hundred units inspection; those for AQLs of 10.0 or less and sample sizes of 80 or less are based on the binomial distribution and are applicable for percent defective inspection; those for AQLs of 10.0 or less and sample sizes larger than 80 are based the Poisson distribution and are applicable either for defects per hundred units inspection, or for percent defective inspection (the Poisson distribution being an adequate approximation to the binomial distribution under these conditions). Tabulated values, corresponding to selected values or probabilities of acceptance ( $P_a$ , in percent) are given for each of the curves shown, and, in addition, for tightened inspection, and for defects per hundred units for AQLs of 10.0 or less and sample sizes of 80 or less.

4.12.2 Average Sample Size Curves. Average sample size curves for double and multiple sampling are in Table IX. These show the average sample sizes which may be expected to occur under the various sampling plans for given levels of process quality. The curves assume no curtailment of inspection and are approximate to the extent that they are based upon the Poisson distribution, and that the sample sizes for double and multiple sampling are assumed to be  $0.631n$  and  $0.25n$  respectively, where  $n$  is the equivalent sample size.



SECTION 5  
TABLES AND CURVES

TABLE I—Sample size code letters

(see 4.9.1 and 4.9.2)

Lot or batch size		Special inspection levels				General inspection levels		
		S-1	S-2	S-3	S-4	I	II	III
2	to	A	A	A	A	A	A	B
9	to	A	A	A	A	A	B	C
16	to	A	A	B	B	B	C	D
26	to	A	B	B	C	C	D	E
51	to	B	B	C	C	C	E	F
91	to	B	B	C	D	D	F	G
151	to	B	C	D	E	E	G	H
281	to	B	C	D	E	F	H	J
501	to	C	C	E	F	G	J	K
1201	to	C	D	E	G	H	K	L
3201	to	C	D	F	G	J	L	M
10001	to	C	D	F	H	K	M	N
35001	to	D	E	G	J	L	N	P
150000	to	D	E	G	J	M	P	Q
500001	and over	D	E	H	K	N	Q	R

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TABLE II-A—Single sampling plans for normal inspection (Master table)

(see 4.9.3 and 4.9.4)

Sample size code letter		Sample size	Acceptable Quality Levels (normal inspection)																																																									
			0.010	0.015	0.025	0.040	0.065	1.0	1.5	2.5	4.0	6.5	10	15	25	40	65	100	150	250	400	650	1000																																					
A	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re																																
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C	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re																														
																															Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re
D	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re																														
																															Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re
E	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re																														
																															Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re
F	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re																														
																															Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re
G	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re																														
																															Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re
H	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re																														
																															Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re
I	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re																														
																															Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re
J	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re																														
																															Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re
K	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re																														
																															Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re
L	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re																														
																															Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re
M	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re																														
																															Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re
N	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re																														
																															Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re
O	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re																														
																															Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re

- Use first sampling plan below arrow. If sample size equals, or exceeds, lot or batch size, do 100 percent inspection.
- ↔ Use first sampling plan above arrow.
- Ac = Acceptance number.
- Re = Rejection number.

SINGLE  
NORMAL

TABLE II-B—Single sampling plans for tightened inspection (Master table)

(see 4.9.3 and 4.9.4)

Sample size code letter		Acceptable Quality Levels (tightened inspection)																											
		0.010	0.015	0.025	0.040	0.065	1.0	1.5	2.5	4.0	6.5	10	15	25	40	65	100	150	250	400	650	1000							
A	2																												
	3																												
	5																												
D	8																												
	13																												
	30																												
G	32																												
	50																												
	80																												
K	125																												
	200																												
	315																												
N	500																												
	800																												
	1250																												
R	2000																												
	3150																												

↓ Use first sampling plan below arrow. If sample size equals or exceeds lot or batch size, do 100 percent inspection.  
 ↓ Use first sampling plan above arrow.  
 Ac = Acceptance number.  
 Re = Rejection number.

TABLE II-C—Single sampling plans for reduced inspection (Master table)

(see 4.9.3 and 4.9.4)

Sample size code letter		Acceptable Quality Levels (reduced inspection) <sup>†</sup>																					
		0.010	0.015	0.025	0.040	0.065	1.0	1.5	2.5	4.0	6.5	10	15	25	40	65	100	150	250	400	650	1000	
Sample size code letter	Sample size	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re
A	2																						
B	2																						
C	2																						
D	3																						
E	5																						
F	8																						
G	13																						
H	20																						
J	32																						
K	50																						
L	80																						
M	125																						
N	200																						
P	315																						
Q	500																						
n	800																						

- Use first sampling plan below arrow.
- Use first sampling plan above arrow.
- Ac = Acceptance number.
- Re = Rejection number.
- † If the acceptance number has been exceeded, but the rejection number has not been reached, accept the lot, but reinspect normal inspection (see 4.10.1.4).

SINGLE  
REDUCED

(see 4.9.3 and 4.9.4)

- ☐ Use first sampling plan below arrow. If sample size equals or exceeds lot or batch size, do 100 percent inspection
- ☐ Use first sampling plan above arrow
- ☐ Acceptance number
- ☐ Rejection number
- ☐ Use corresponding single sampling plan (or alternative, use double sampling plan below, where available)

## DOUBLE NORMAL

TABLE III-B—Double sampling plans for tightened inspection (Master table)  
(see 4.9.3 and 4.9.4)

			Acceptable Quality Levels (tightened inspection)																											
Sample size code letter	Sample size	Lot size	0.010	0.015	0.025	0.040	0.060	0.100	0.150	0.250	0.400	0.650	1.00	1.50	2.50	4.00	6.50	10	15	25	40	65	100	150	250	400	650	1000		
A																														
B	2	2																												
C	3	3																												
D	5	5																												
E	8	8																												
F	13	13																												
G	20	20																												
H	32	32																												
I	50	50																												
J	80	80																												
K	125	125																												
L	200	200																												
M	315	315																												
N	500	500																												
O	800	800																												
P	1250	1250																												
Q	2000	2000																												
R	3150	3150																												

Use first sampling plan below arrow. If sample size equals or exceeds lot or batch size, do 100 percent inspection.  
 Use first sampling plan above arrow.  
 Ac = Acceptance number.  
 Re = Rejection number.  
 Use corresponding single sampling plan (see, alternatively, use double sampling plan below, where available).

DOUBLE  
TIGHTENED

(see 4.9.3 and 4.9.4)

Use first sampling plus below arrow. If sample size equals or exceeds lot or batch size, do 100 percent inspection.

- ☒ Use first sampling plus below arrow.
- ☒ Use first sampling plus above arrow.

$\lambda_c$  = Acceptance number.  
 $\lambda_n$  = Rejection number.

Hu = Hypothesis number.  
 \* Use corresponding single sampling plan for alternatively, use double sampling plan below, where available.)

- Use corresponding single sampling plan (or alternatively, use double sampling plan below, when available.)
- If, after the second sample, the acceptance number has been exceeded, but the rejection number has not been reached, accept the lot, but reinspect around inspection point 4.12.1.4)

**DOUBLE  
REDUCED**



TABLE IV-A—Multiple sampling plans for normal inspection (Master table)

(see 4.9.3 and 4.9.4)

		Acceptable Quality Levels (normal inspection)																										
		0.010	0.015	0.025	0.040	0.065	0.10	0.15	0.25	0.40	0.65	1.0	1.5	2.5	4.0	6.5	10	15	25	40	65	100	150	250	400	650	1000	
Sample size code letter	Sample size	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	
A		Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	
B		Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	
C		Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	
D		Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	
E		Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	
F		Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	
G		Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	
H		Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	
I		Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	

\* The first sampling plan below some (refer to continuation of table on following page, when necessary). If sample also equals or exceeds the number shown, do 100 percent inspection.  
 Ac = Acceptance number  
 Re = Rejection number  
 \* The corresponding single sampling plan for alternative, use multiple sampling plan below, where available.  
 \* The corresponding double sampling plan for alternative, use multiple sampling plan below, where available.  
 \* Acceptance not permitted at this sample size.

MULTIPLE  
NORMAL

**MULTIPLE  
NORMAL**

- 1. Use first sampling plan below: *none*. If sample size equals or exceeds lot or batch size, do 100 percent inspection
- 2. Use first sampling plan above *unless* prior to preceding page, when necessary
- 3. Acceptance number
- 4. Use corresponding single sampling plan (or alternatively, use multiple plan below, where available)
- 5. Acceptance number permitted in this sample size.

**MULTIPLE  
TIGHTENED**

- Use first sampling plan below error (refer to continuation of table on following page, when necessary). If sample also equals or exceeds lot or batch size, do 100 percent inspection.
- Use first sampling plan above error
- Acceptance = number
- Rejection = number
- Use corresponding single sampling plan (see alternative), use multiple sampling plan below, where available.
- Use corresponding double sampling plan (see alternative), use multiple sampling plan below, where available.
- Acceptance not permitted at this sample size

TABLE IV-B—Multiple sampling plans for tightened inspection (Master table)  
(see 4.9.3 and 4.9.4)

(Continued)

Acceptable Quality Levels (tightened inspection)																										
Sample size code letter	Sample size	Cumulative sample size	0.010	0.015	0.025	0.040	0.065	1.0	1.5	2.5	4.0	6.5	10	15	25	40	65	100	150	250	400	650	1000			
			Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re		
A	First	32	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→			
	Second	44	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→				
	Third	50	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→				
	Fourth	64	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→				
	Fifth	80	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→				
	Sixth	100	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→				
	Seventh	125	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→				
L	First	50	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→				
	Second	64	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→				
	Third	80	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→				
	Fourth	100	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→				
	Fifth	125	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→				
	Sixth	160	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→				
	Seventh	200	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→				
H	First	80	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→				
	Second	100	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→				
	Third	125	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→				
	Fourth	160	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→				
	Fifth	200	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→				
	Sixth	250	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→				
	Seventh	320	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→				
V	First	125	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→				
	Second	160	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→				
	Third	200	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→				
	Fourth	250	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→				
	Fifth	320	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→				
	Sixth	400	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→				
	Seventh	500	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→				
P	First	200	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→				
	Second	250	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→				
	Third	320	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→				
	Fourth	400	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→				
	Fifth	500	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→				
	Sixth	630	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→				
	Seventh	800	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→				
O	First	315	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→				
	Second	400	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→				
	Third	500	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→				
	Fourth	630	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→				
	Fifth	800	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→				
	Sixth	1000	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→				
	Seventh	1250	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→				
N	First	500	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→				
	Second	630	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→				
	Third	800	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→				
	Fourth	1000	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→				
	Fifth	1250	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→				
	Sixth	1600	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→				
	Seventh	2000	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→				
S	First	800	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→				
	Second	1000	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→				
	Third	1250	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→				
	Fourth	1600	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→				
	Fifth	2000	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→					

\* Use first sampling plan in row arrow. If sample size equals or exceeds lot or batch size, do 100 percent inspection.  
 \* Use first sampling plan above arrow (refer to preceding page, when necessary).  
 \* Acceptance number.  
 \* Rejection number.  
 \* Use corresponding single sampling plan (or alternative); see multiple sampling plan below, when available.  
 \* Acceptance and rejection numbers at this sample size.

MULTIPLE  
TIGHTENED



TABLE IV-C—Multiple sampling plans for reduced inspection (Master table)  
(Continued)

(see 4.9.3 and 4.9.4)

		Acceptable Quality Levels (reduced inspection) <sup>1</sup>																					
		0.010	0.015	0.025	0.040	0.065	1.0	1.5	2.5	4.0	6.5	10	15	25	40	65	100	150	250	400	650	1000	
Sample size code letter	Sample size	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re
L	First																						
	Second																						
	Third																						
	Fourth																						
	Fifth																						
	Sixth																						
	Seventh																						
M	First																						
	Second																						
	Third																						
	Fourth																						
	Fifth																						
	Sixth																						
	Seventh																						
N	First																						
	Second																						
	Third																						
	Fourth																						
	Fifth																						
	Sixth																						
	Seventh																						

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2	0	3	9	6	12	←	0	5	0	6	←	0	6	←	3	9	6	12	18	22	←	0	6	←	3	9	6	12	18	22	←
3	10	5	12	0	15		3	9	6	12		6	12		11	17															
5	11	7	13	11	17		5	12	0	15		7	13		11	17	10	15	14	20											
7	12	10	15	14	20		10	15	14	20		13	17		18	22	14	20	18	22											
9	14	13	17	18	22		13	17	18	22		16	21		23	27	16	21	23	27											
0	5	0	6	←	0	6	←	3	9	6	←	3	9	6	12	18	22	←	0	6	←	3	9	6	12	18	22	←			
1	7	3	9		6	12		6	12	11		17	9	12	0	15	10		15	14		20									
3	9	6	12		11	17		5	12	0		15	7	13	11	17	10		15	14		20									
5	11	7	13		11	17		5	12	0		15	7	13	11	17	10		15	14		20									
7	12	10	15		14	20		10	15	14		20	13	17	18	22	14		20	18		22									
0	6	←	3	9	6	←	3	9	6	←	3	9	6	12	18	22	←	0	6	←	3	9	6	12	18	22	←				
1	7		3	9	6		12	6	12		11	17	9	12	0	15		10	15		14	20									
3	9		6	12	11		17	5	12		0	15	7	13	11	17		10	15		14	20									
5	11		7	13	11		17	5	12		0	15	7	13	11	17		10	15		14	20									
7	12		10	15	14		20	10	15		14	20	13	17	18	22		14	20		18	22									
0	6	←	3	9	6	←	3	9	6	←	3	9	6	12	18	22	←	0	6	←	3	9	6	12	18	22	←				
1	7		3	9	6		12	6	12		11	17	9	12	0	15		10	15		14	20									
3	9		6	12	11		17	5	12		0	15	7	13	11	17		10	15		14	20									
5	11		7	13	11		17	5	12		0	15	7	13	11	17		10	15		14	20									
7	12		10	15	14		20	10	15		14	20	13	17	18	22		14	20		18	22									
0	6	←	3	9	6	←	3	9	6	←	3	9	6	12	18	22	←	0	6	←	3	9	6	12	18	22	←				
1	7		3	9	6		12	6	12		11	17	9	12	0	15		10	15		14	20									
3	9		6	12	11		17	5	12		0	15	7	13	11	17		10	15		14	20									
5	11		7	13	11		17	5	12		0	15	7	13	11	17		10	15		14	20									
7	12		10	15	14		20	10	15		14	20	13	17	18	22		14	20		18	22									
0	6	←	3	9	6	←	3	9	6	←	3	9	6	12	18	22	←	0	6	←	3	9	6	12	18	22	←				
1	7		3	9	6		12	6	12		11	17	9	12	0	15		10	15		14	20									
3	9		6	12	11		17	5	12		0	15	7	13	11	17		10	15		14	20									
5	11		7	13	11		17	5	12		0	15	7	13	11	17		10	15		14	20									
7	12		10	15	14		20	10	15		14	20	13	17	18	22		14	20		18	22									
0	6	←	3	9	6	←	3	9	6	←	3	9	6	12	18	22	←	0	6	←	3	9	6	12	18	22	←				
1	7		3	9	6		12	6	12		11	17	9	12	0	15		10	15		14	20									
3	9		6	12	11		17	5	12		0	15	7	13	11	17		10	15		14	20									
5	11		7	13	11		17	5	12		0	15	7	13	11	17		10	15		14	20									
7	12		10	15	14		20	10	15		14	20	13	17	18	22		14	20		18	22									
0	6	←	3	9	6	←	3	9	6	←	3	9	6	12	18	22	←	0	6	←	3	9	6	12	18	22	←				
1	7		3	9	6		12	6	12		11	17	9	12	0	15		10	15		14	20									
3	9		6	12	11		17	5	12		0	15	7	13	11	17		10	15		14	20									
5	11		7	13	11		17	5	12		0	15	7	13	11	17		10	15		14	20									
7	12		10	15	14		20	10	15		14	20	13	17	18	22		14	20		18	22									
0	6	←	3	9	6	←	3	9	6	←	3	9	6	12	18	22	←	0	6	←	3	9	6	12	18	22	←				
1	7		3	9	6		12	6	12		11	17	9	12	0	15		10	15		14	20									
3	9		6	12	11		17	5	12		0	15	7	13	11	17		10	15		14	20									
5	11		7	13	11		17	5	12		0	15	7	13	11	17		10	15		14	20									
7	12		10	15	14		20	10	15		14	20	13	17	18	22		14	20		18	22									
0	6	←	3	9	6	←	3	9	6	←	3	9	6	12	18	22	←	0	6	←	3	9	6	12	18	22	←				
1	7		3	9	6		12	6	12		11	17	9	12	0	15		10	15		14	20									
3	9		6	12	11		17	5	12		0	15	7	13	11	17		10	15		14	20									
5	11		7	13	11		17	5	12		0	15	7	13	11	17		10	15		14	20									
7	12		10	15	14		20	10	15		14	20	13	17	18	22		14	20		18	22									
0	6	←	3	9	6	←	3	9	6	←	3	9	6	12	18	22	←	0	6	←	3	9	6	12	18	22	←				
1	7		3	9	6		12	6	12		11	17	9	12	0	15		10	15		14	20									
3	9		6	12	11		17	5	12		0	15	7	13	11	17		10	15		14	20									
5	11		7	13	11		17	5	12		0	15	7	13	11	17		10	15		14	20									
7	12		10	15	14		20	10	15		14	20	13	17	18	22		14	20		18	22									
0	6	←	3	9	6	←	3	9	6	←	3	9	6	12	18	22	←	0	6	←	3	9	6	12	18	22	←				
1	7		3	9	6		12	6	12		11	17	9	12	0	15		10	15		14	20									
3	9		6	12	11		17	5	12		0	15	7	13	11	17		10	15		14	20									
5	11		7	13	11		17	5	12		0	15	7	13	11	17		10	15		14	20									
7	12		10	15	14		20	10	15		14	20	13	17	18	22		14	20		18	22									
0	6	←	3	9	6	←	3	9	6	←	3	9	6	12	18	22	←	0	6	←	3	9	6	12	18	22	←				
1	7		3	9	6		12	6	12		11	17	9	12	0	15		10	15		14	20									
3	9		6	12	11		17	5	12		0	15	7	13	11	17		10	15		14	20									
5	11		7	13	11		17	5	12		0	15	7	13	11	17		10	15		14	20									
7	12		10	15	14		20	10	15		14	20	13	17	18	22		14	20		18	22									
0	6	←	3	9	6	←	3	9	6	←	3	9	6	12	18	22	←	0	6	←	3	9	6	12	18	22	←				
1	7		3	9	6		12	6	12		11	17	9	12	0	15		10	15		14	20									
3	9		6	12	11		17	5	12		0	15	7	13	11	17		10	15		14	20									
5	11		7	13	11		17	5	12		0	15	7	13	11	17		10	15		14	20									
7	12		10	15	14		20	10	15		14	20	13	17	18	22		14	20		18	22									
0	6	←	3	9	6	←	3	9	6	←	3	9	6	12	18	22	←	0	6	←	3	9	6	12	18	22	←				
1	7		3																												

1. If sample size equals, or is less than, the lot size, the first sampling plan above arrow (refer to preceding page also).

MULTIPLE  
REDUCED

2. If rejection number has not been reached, accept the lot, but reinspect normal inspection (see 4.10.1.4).

3. If, after the final sample, the acceptance number has been reached.

- Use first sampling plan below arrow. If sample size equals, or is less than, the lot size, the first sampling plan above arrow (refer to preceding page also).
- Acceptance number
- Rejection number
- Acceptance number
- Rejection number

TABLE V-A—Average Outgoing Quality Limit Factors for Normal Inspection (Single sampling) \*

(see 3.3)

Code Letter	Sample Size	Acceptable Quality Level																				
		0.010	0.015	0.025	0.040	0.065	1.0	1.5	2.5	4.0	6.5	10	15	25	40	65	100	150	250	400	650	1000
A	2																					
B	3																					
C	5																					
D	8																					
E	13																					
F	20																					
G	32																					
H	50																					
J	80																					
K	125																					
L	200																					
M	315																					
N	500																					
P	800																					
Q	1250																					
R	2000																					

\* Notes: For the exact AOQL, the above values must be multiplied by  $(1 - \frac{\text{Sample size}}{\text{Lot or Batch size}})$

AOQL  
NORMAL

TABLE V.B—Average Outgoing Quality Limit Factors for Tightened Inspection (Single sampling)\*

(see 3.3)

Code letter		Sample size	Acceptable Quality Level																																	
			0.010	0.015	0.025	0.040	0.065	0.10	0.15	0.25	0.40	0.65	1.0	1.5	2.5	4.0	6.5	10	15	25	40	65	100	150	200	300	400	500	600	700	800	900	1000			
A	2																																			
B	3																																			
C	5																																			
D	8																																			
E	13																																			
F	20																																			
G	32																																			
H	50																																			
I	80																																			
J	125																																			
K	200																																			
L	300																																			
M	400																																			
N	500																																			
P	600																																			
Q	1200																																			
R	2000																																			
S	3150																																			

\* Notes: For the exact AOQL, the above values must be multiplied by  $(1 - \frac{\text{Sample size}}{\text{Lot or Batch size}})$  (see 11.4)



TABLE VI-A—Limiting Quality (in percent defective) for which  $P_d = 10$  Percent  
(for Normal Inspection, Single sampling)

(see 4.11)

Code letter	Sample size	Acceptable Quality Level										
		0.010	0.015	0.025	0.040	0.065	1.0	1.5	2.5	4.0	6.5	10
A	2	0.29	0.46	0.73	1.2	1.8	2.8	4.5	6.9	11	16	25
B	3											
C	5											
D	8	0.18	0.20	0.33	0.46	0.53	0.74	0.84	0.94	1.2	1.5	1.9
E	13											
F	20											
G	32	0.18	0.20	0.27	0.33	0.43	0.54	0.65	0.76	0.82	0.94	1.1
H	50											
J	80											
K	125	0.18	0.20	0.27	0.33	0.43	0.54	0.65	0.76	0.82	0.94	1.1
L	200											
M	315											
N	500	0.18	0.20	0.27	0.33	0.43	0.54	0.65	0.76	0.82	0.94	1.1
P	800											
Q	1250											
R	2000	0.18	0.20	0.27	0.33	0.43	0.54	0.65	0.76	0.82	0.94	1.1

LQ (DEFECTIVES)  
10.0%

TABLE VI-B—Limiting Quality (in defects per hundred units) for which  $P_a = 10$  Percent  
(for Normal Inspection, Single sampling)

(see 4.11)

Code letter	Sample size	Acceptable Quality Level																					
		0.010	0.015	0.025	0.040	0.065	1.0	1.5	2.5	4.0	6.5	10	15	25	40	65	100	150	250	400	650	1000	
A	2																						
B	3																						
C	5																						
D	8																						
E	13																						
F	20																						
G	32																						
H	50																						
J	80																						
K	125																						
L	200																						
M	315																						
N	500																						
P	800																						
Q	1250																						
U	2000																						

**TABLE VII-A—Limiting Quality (in percent defective) for which  $P_d = 5$  Percent**  
 (for Normal Inspection, Single sampling)

(see 4.11)

Code letter	Sample size	Acceptable Quality Level										
		0.010	0.015	0.025	0.040	0.065	0.10	0.15	0.25	0.40	0.65	1.0
A	2											
B	3											
C	5											
D	8											
E	13											
F	20											
G	32											
H	50											
J	80											
K	125											
L	200											
M	315											
N	500											
P	800											
Q	1250											
R	2000											

**LQ (DEFECTIVES)**  
**5.0%**

**TABLE VII-B—Limiting Quality (in defects per hundred units) for which  $P_a = 5$  Percent**  
 (for Normal Inspection, Single sampling)

(see 4.11)

Code letter	Sample size	Acceptable Quality Level																400	650	1000
		0.010	0.015	0.025	0.040	0.065	1.0	1.5	2.5	4.0	6.5	10	15	25	40	65	100	150	250	400
A	2																			
B	3																			
C	5																			
D	8																			
E	13																			
F	20																			
G	32																			
H	50																			
J	80																			
K	125																			
L	200																			
M	315																			
N	500																			
P	800																			
Q	1250																			
R	2000																			

TABLE VIII—Limit Numbers for Reduced Inspection

(see 4.7.3)

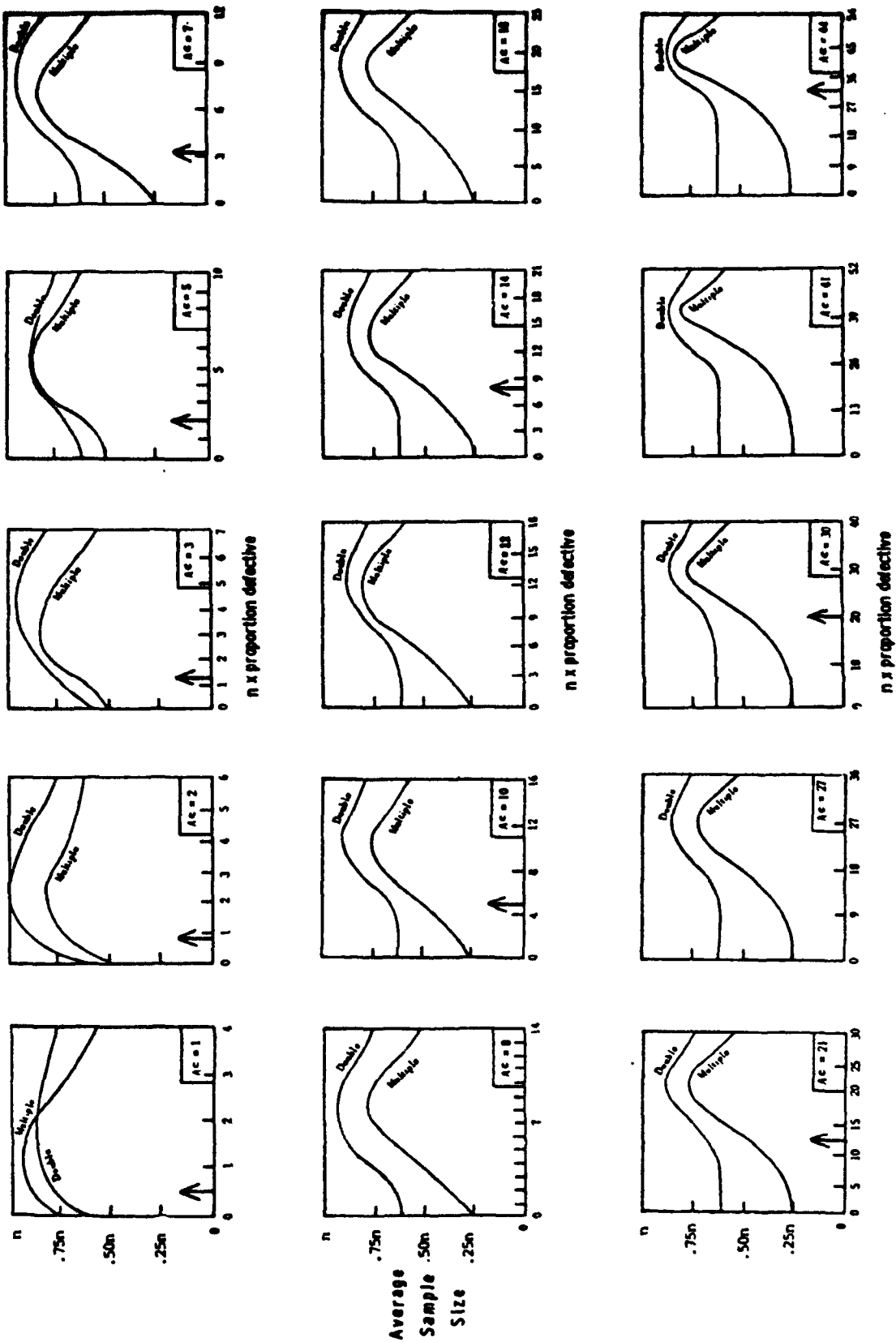
Number of sample units from lot or batches	Acceptable Quality Level																		
	0.010	0.015	0.025	0.040	0.065	1.0	1.5	2.5	4.0	6.5	10	15	25	40	65	100	150	250	400
20 - 29	.	.	.	.	.	.	.	.	.	.	.	.	2	4	8	14	22	40	68
30 - 49	.	.	.	.	.	.	.	.	.	.	.	.	3	7	13	22	38	63	105
50 - 79	.	.	.	.	.	.	.	.	.	.	2	3	7	14	25	40	63	110	181
80 - 129	.	.	.	.	.	.	.	8	0	2	4	7	14	24	42	68	105	181	277
130 - 199	.	.	.	.	.	.	.	0	2	4	7	13	25	42	72	115	177	301	490
200 - 319	.	.	.	.	.	.	.	0	2	4	8	14	40	68	115	181	277	471	
320 - 499	.	.	.	.	.	.	.	4	8	14	24	39	68	113	189				
500 - 799	.	.	.	.	.	.	.	7	14	25	40	63	110	181					
800 - 1249	.	.	.	.	.	.	.	14	24	42	68	105	181						
1250 - 1999	.	.	.	.	.	.	.	24	40	69	110	169							
2000 - 3149	.	.	.	.	.	.	.	40	68	115	181								
3150 - 19999	.	.	.	.	.	.	.	110	181	186									
20000 - 31499	0	0	2	4	8	14	22	40	68	115	181								
31500 & Over	0	1	4	8	16	24	38	67	111	186									

• (Notes that the number of sample units from the lot or batches is not sufficient for reduced inspection for this AQL. In this instance more than ten lots or batches may be used for the calculation, provided that the lots or batches used are the most recent ones in sequence, that they have all been on normal inspection, and that none has been rejected while on original inspection.)

LIMIT  
NUMBERS

TABLE IX—Average sample size curves for double and multiple sampling  
(normal and tightened inspection)

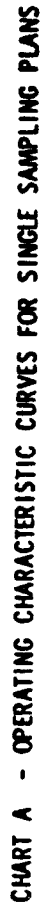
(see 4.12.2)



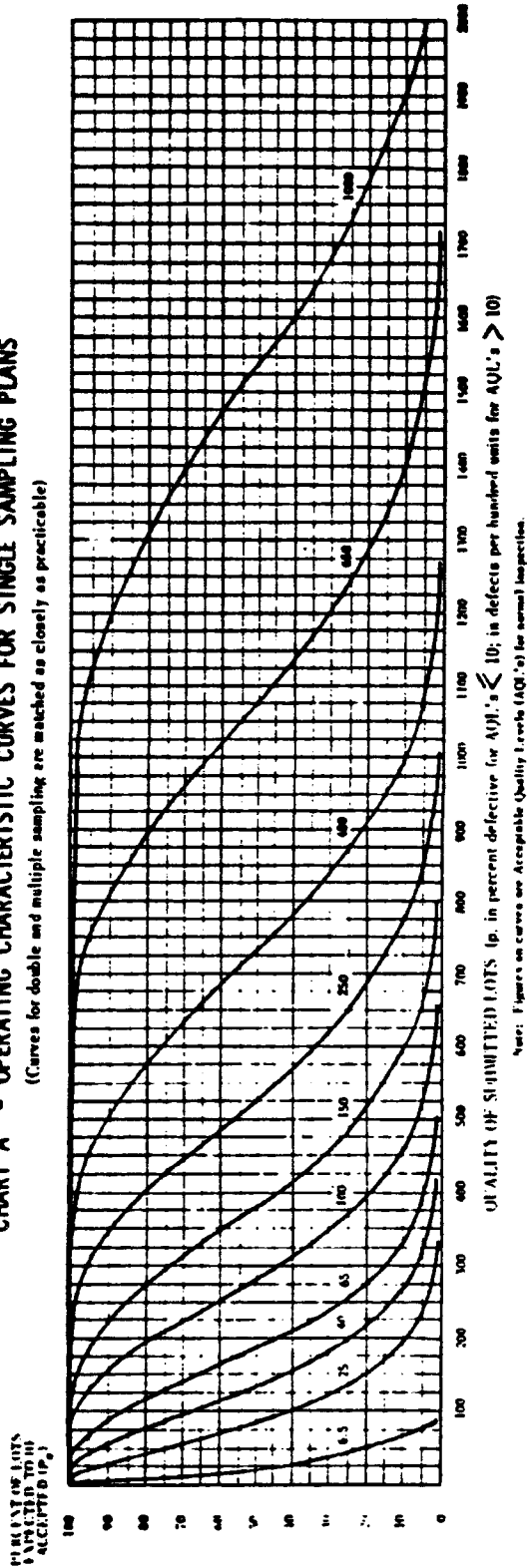
$n$  = Equivalent single sample size  
 $Ac$  = Single sample acceptance number  
 $\uparrow$  = AQL for normal inspection

AVERAGE  
SAMPLE SIZE

**TABLE X-A—Tables for sample size code letter: A**



(Curves for double and multiple sampling are matched as closely as practicable)



**TABLE X-A-1 - TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS**

P <sub>o</sub>	Acceptable Quality Levels (normal inspection)														
	6.5	6.5	25	40	65	100	150	250	400	650	1000				
	p (in defects per hundred units)														
99.0	0.501	0.503	7.41	21.8	41.2	89.3	145	175	239	305	374	517	629	859	977
95.0	2.53	2.56	17.8	40.9	68.3	131	199	235	308	381	462	622	745	995	1122
90.0	5.13	5.27	26.6	55.1	87.2	158	233	272	351	432	515	684	812	1073	1206
75.0	13.4	14.4	48.1	86.4	127	211	298	342	431	521	612	795	934	1214	1354
50.0	29.3	34.7	83.9	134	184	284	383	433	533	633	733	933	1083	1383	1533
25.0	50.0	69.3	135	196	255	371	484	540	651	761	870	1087	1248	1548	1728
10.0	68.4	115	194	266	334	444	589	650	770	889	1006	1238	1409	1748	1916
5.0	77.6	150	237	315	388	526	657	722	848	972	1094	1335	1512	1862	2035
1.0	90.0	239	332	420	502	655	800	870	1007	1141	1272	1529	1718	2089	2270
	X	X	40	65	100	150	X	250	X	400	X	650	X	1000	X
	Acceptable Quality Levels (tightened inspection)														

**Notes:** Binomial distribution used for percent defective comparisons; Poisson for defects per hundred units.

TABLE X-A-2 - SAMPLING PLANS FOR SAMPLE SIZE CODE LETTER: A

Type of sampling plan	Cumulative sample size	Acceptable Quality Levels (normal inspection)																	Cumulative sample size	
		Less than 6.5	6.5	10	15	25	40	65	100	150	250	400	650	1000						
		Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re		
Single	2	▽	0 1			1 2	2 3	3 4	5 6	7 8	9 10	11 12	13 14	15 16	18 19	21 22	27 28	30 31	2	
Double		▽	•	Use code Letter D	Use code Letter C	Use code Letter B	(*)	(*)	(*)	(*)	(*)	(*)	(*)	(*)	(*)	(*)	(*)	(*)		
Multiple		▽	•			•	•	•	•	•	•	•	•	•	•	•	•	•		
		Less than 10	10	15	25	40	65	100	150	250	400	650	1000	X						X
Acceptable Quality Levels (tightened inspection)																				

▽ = Use next subsequent sample size code letter for which acceptance and rejection numbers are available.

Ac = Acceptance number

Re = Rejection number

• = Use single sampling plan above (or alternatively use code letter D).

(\*) = Use single sampling (or alternatively use code letter B).

A



TABLE X-B—Tables for sample size code letter: B

CHART B - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

(Curves for double and multiple sampling are matched as closely as practicable)

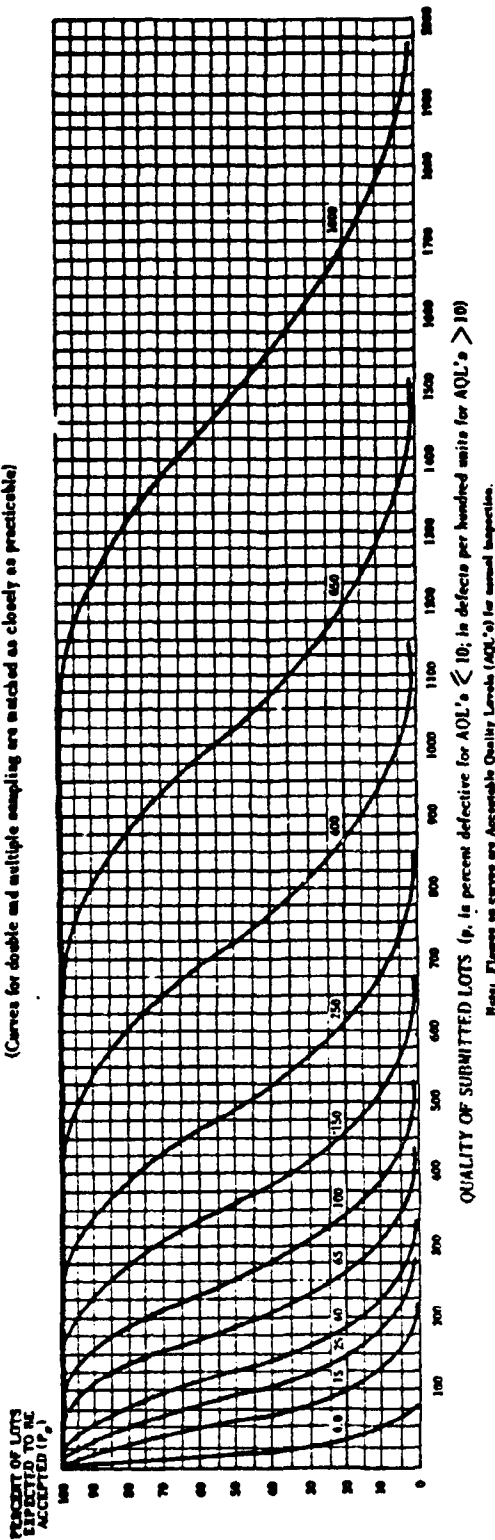


TABLE X-B-1 - TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

P <sub>a</sub>	Acceptable Quality Levels (normal inspection)															
	4.0	6.5	10	15	25	40	65	100	150	200	250	300	400	500	650	1000
	p (in percent defective)															
99.0	0.335	0.335	0.335	0.335	0.335	0.335	0.335	0.335	0.335	0.335	0.335	0.335	0.335	0.335	0.335	0.335
95.0	1.71	1.71	1.71	1.71	1.71	1.71	1.71	1.71	1.71	1.71	1.71	1.71	1.71	1.71	1.71	1.71
90.0	3.51	3.51	3.51	3.51	3.51	3.51	3.51	3.51	3.51	3.51	3.51	3.51	3.51	3.51	3.51	3.51
75.0	9.59	9.59	9.59	9.59	9.59	9.59	9.59	9.59	9.59	9.59	9.59	9.59	9.59	9.59	9.59	9.59
50.0	23.1	23.1	23.1	23.1	23.1	23.1	23.1	23.1	23.1	23.1	23.1	23.1	23.1	23.1	23.1	23.1
25.0	46.2	46.2	46.2	46.2	46.2	46.2	46.2	46.2	46.2	46.2	46.2	46.2	46.2	46.2	46.2	46.2
10.0	76.8	76.8	76.8	76.8	76.8	76.8	76.8	76.8	76.8	76.8	76.8	76.8	76.8	76.8	76.8	76.8
5.0	99.9	99.9	99.9	99.9	99.9	99.9	99.9	99.9	99.9	99.9	99.9	99.9	99.9	99.9	99.9	99.9
1.0	154	154	154	154	154	154	154	154	154	154	154	154	154	154	154	154
	6.5	6.5	6.5	6.5	6.5	6.5	6.5	6.5	6.5	6.5	6.5	6.5	6.5	6.5	6.5	6.5
	Acceptable Quality Levels (tightened insp.: 100)															
	4.0	6.5	10	15	25	40	65	100	150	200	250	300	400	500	650	1000
	p (in defects per hundred units)															
	96.9	96.9	96.9	96.9	96.9	96.9	96.9	96.9	96.9	96.9	96.9	96.9	96.9	96.9	96.9	96.9
	133	133	133	133	133	133	133	133	133	133	133	133	133	133	133	133
	155	155	155	155	155	155	155	155	155	155	155	155	155	155	155	155
	199	199	199	199	199	199	199	199	199	199	199	199	199	199	199	199
	256	256	256	256	256	256	256	256	256	256	256	256	256	256	256	256
	323	323	323	323	323	323	323	323	323	323	323	323	323	323	323	323
	360	360	360	360	360	360	360	360	360	360	360	360	360	360	360	360
	413	413	413	413	413	413	413	413	413	413	413	413	413	413	413	413
	481	481	481	481	481	481	481	481	481	481	481	481	481	481	481	481
	565	565	565	565	565	565	565	565	565	565	565	565	565	565	565	565
	648	648	648	648	648	648	648	648	648	648	648	648	648	648	648	648
	730	730	730	730	730	730	730	730	730	730	730	730	730	730	730	730
	848	848	848	848	848	848	848	848	848	848	848	848	848	848	848	848
	1019	1019	1019	1019	1019	1019	1019	1019	1019	1019	1019	1019	1019	1019	1019	1019
	1145	1145	1145	1145	1145	1145	1145	1145	1145	1145	1145	1145	1145	1145	1145	1145
	1392	1392	1392	1392	1392	1392	1392	1392	1392	1392	1392	1392	1392	1392	1392	1392
	1513	1513	1513	1513	1513	1513	1513	1513	1513	1513	1513	1513	1513	1513	1513	1513
	1951	1951	1951	1951	1951	1951	1951	1951	1951	1951	1951	1951	1951	1951	1951	1951
	2069	2069	2069	2069	2069	2069	2069	2069	2069	2069	2069	2069	2069	2069	2069	2069
	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000

Note: Binomial distribution used for percent defective comparisons; Poisson for defects per hundred units.

TABLE X-B-2 - SAMPLING PLANS FOR SAMPLE SIZE CODE LETTER: B

Type of sampling plan	Cumulative sample size	Acceptable Quality Levels (normal inspection)																	Cumulative sample size			
		Less than 4.0	4.0	6.5	10	15	25	40	65	100	150	250	400	650	1000							
		Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re						
Single	3	▽	0 1			1 2	2 3	3 4	5 6	7 8	8 9	10 11	12 13	14 15	18 19	21 22	27 28	30 31	41 42	44 45	3	
				Use	Use																	
Double	2	▽	•			0 2	3 1	4 2	5 3	7 3	7 5	9 6	10 7	11 9	14 11	16 15	20 17	22 23	29 25	31	2	
	4			code Letter	code Letter	1 2	3 4	4 5	6 7	8 9	11 12	12 13	15 16	18 19	23 24	26 27	34 35	37 38	52 53	56 57	4	
Multiple		▽	•																			
				A	D	C																
		Less than 6.5	6.5	10	15	25	40	65	100	150	250	400	650	1000	1000							
																	Acceptable Quality Levels (tightened inspection)					

▽ = Use next subsequent sample size code letter for which acceptance and rejection numbers are available.

Ac = Acceptance number

Re = Rejection number

• = Use single sampling plan above (or alternatively use code letter E)

++ = Use double sampling plan above (or alternatively use code letter D)

B

TABLE X-C—Tables for sample size code letter: C

CHART C - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

(Curves for double and multiple sampling are matched as closely as practicable)

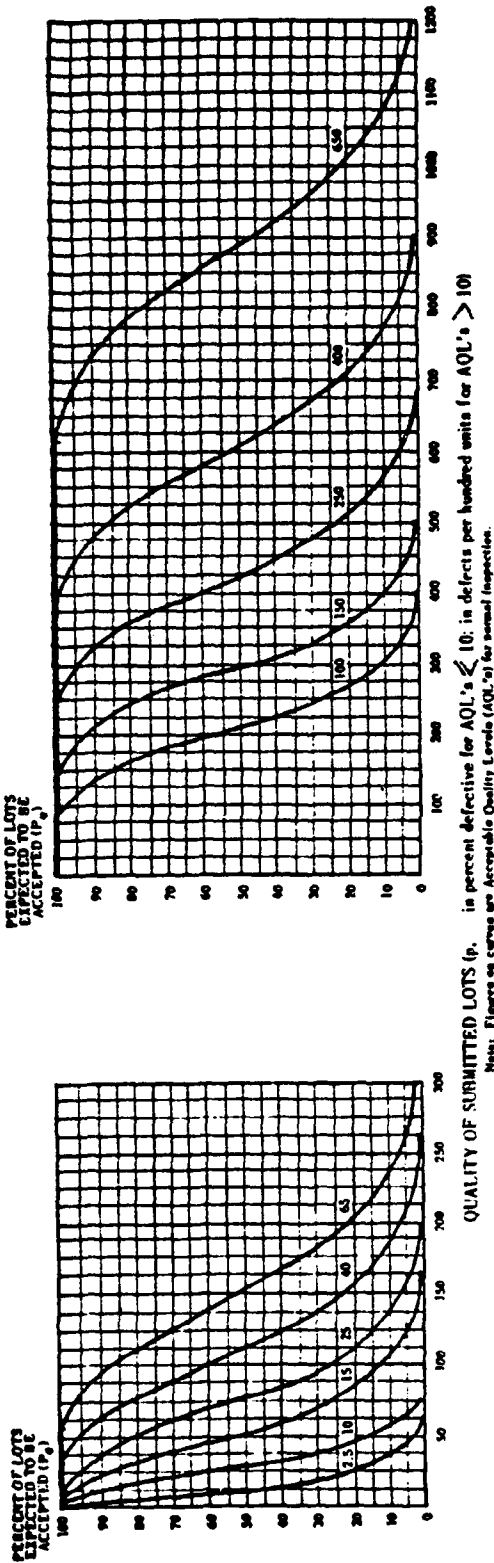


TABLE X-C-1 - TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

$P_a$	Acceptable Quality Levels (normal inspection)														Acceptable Quality Levels (tightened inspection)													
	2.5	10	2.5	10	15	25	40	65	100	150	207	251	343	391	400	400	400	400	400	400	400	400	400	400	400	400	400	400
	$p$ (in percent defective)														$p$ (in defects per hundred units)													
99.0	0.201	3.27	0.201	2.97	8.72	16.5	37.5	58.1	70.1	95.4	122	150	207	251	343	391	400	400	400	400	400	400	400	400	400	400	400	400
95.0	1.02	7.64	1.01	7.11	16.4	27.3	52.3	79.6	93.9	123	154	185	249	298	398	449	469	469	469	469	469	469	469	469	469	469	469	469
90.0	2.09	11.2	2.11	10.6	22.0	34.9	63.0	93.1	109	140	173	206	273	325	429	482	499	499	499	499	499	499	499	499	499	499	499	499
75.0	5.59	19.4	5.75	19.2	34.5	50.7	84.4	119	137	172	208	245	318	374	485	542	564	564	564	564	564	564	564	564	564	564	564	564
50.0	12.9	31.4	13.9	33.6	53.5	73.4	113	153	173	213	253	293	373	433	553	613	613	613	613	613	613	613	613	613	613	613	613	613
25.0	24.2	45.4	27.7	53.9	78.4	102	148	194	216	260	304	348	435	499	627	691	691	691	691	691	691	691	691	691	691	691	691	691
10.0	36.9	58.4	46.1	77.8	106	134	185	235	260	308	356	403	495	564	699	766	766	766	766	766	766	766	766	766	766	766	766	766
5.0	45.1	65.7	59.9	94.9	126	155	210	263	289	339	389	438	534	605	745	814	814	814	814	814	814	814	814	814	814	814	814	814
1.0	60.2	77.8	92.1	131	168	201	262	320	348	403	456	509	612	687	835	908	908	908	908	908	908	908	908	908	908	908	908	908
	4.0	7.0	4.0	7.0	10.0	13.0	17.0	21.0	24.0	28.0	32.0	36.0	44.0	50.0	62.0	68.0	68.0	68.0	68.0	68.0	68.0	68.0	68.0	68.0	68.0	68.0	68.0	68.0

Note: Binomial distribution used for percent defective computations. Figures for defects per hundred units.

TABLE X-C-2 - SAMPLING PLANS FOR SAMPLE SIZE CODE LETTER: C

Type of sampling plan	Cumulative sample size	Acceptable Quality Levels (tightened inspection)																Cumulative sample size
		Less than 2.5	2.5	4.0	6.5	10	15	25	40	65	100	150	250	400	650	1000		
		Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	
Single	5	▽	0 1			1 2 2 3 3 4	5 6 7 8	9 10 11 12	13 14 15 16 17 18 19 20 21 22	23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39 40 41 42 43 44 45							5	
Double	3	▽	•	Use	Use	0 2 0 3 1 4	5 3 7 3 3 7 5 9 6 10 7 11 9 14 11 16 15 20 17 22 23 29 25 31									Use	3	
	6			code Letter	code Letter	1 2 3 4 4 5 6 7 8 9 11 12 13 15 16 18 19 23 24 26 27 34 35 37 38 52 53 56 57										code Letter	6	
Multiple		▽	•	B	E												B	
	Less than 4.0		4.0	6.5	10	15	25	40	65	100	150	250	400	650	1000			

▽ = Use next subsequent sample size code letter for which acceptance and rejection numbers are available.

Ac = Acceptance number.

Re = Rejection number.

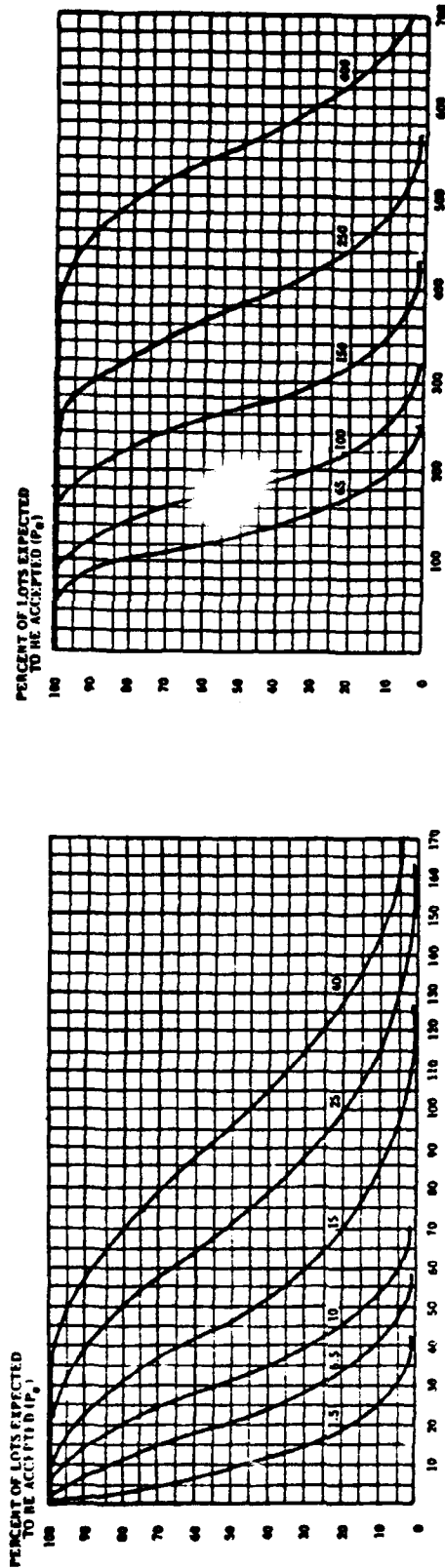
• = Use single sampling plan above (or alternatively use code letter F)

++ = Use double sampling plan above (or alternatively use code letter D)

**TABLE X-D—Tables for sample size code letter: D**

### CHART D - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

(Curves for double and multiple sampling are matched as closely as practicable)



QUALITY OF SUBMITTED LOTS ( $p$ , in percent defective for AQL's  $\leq 10$ ; in defects per hundred units for AQL's  $> 10$ )

**Note:** Figures on curves are Acceptable Quality Levels (AQL's) for normal inspection.

TABLE X-D-1 - TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

P <sub>0</sub>	Acceptable Quality Levels (normal inspection)																Acceptable Quality Levels (tightened inspection)															
	p (in percent defective)								p (in defects per hundred units)																							
	1.5	6.5	10	15	25	40	65	100	150	250	400	150	250	400	150	250	400															
99.0	0.126	1.97	6.08	10.3	22.3	36.3	43.8	59.6	76.2	93.5	129	157	215	244	355	386																
95.0	0.639	4.64	11.1	17.1	32.7	49.8	58.7	77.1	96.1	116	156	186	249	281	399	432																
90.0	1.31	6.88	14.7	21.8	39.4	58.2	67.9	87.8	108	129	171	203	268	301	424	458																
75.0	3.53	12.1	22.1	31.7	52.7	74.5	85.5	108	130	153	199	234	303	339	468	504																
50.0	8.30	20.1	32.1	45.9	70.9	95.9	108	133	158	183	233	271	346	383	521	558																
25.0	15.9	30.3	43.3	63.9	92.8	121	135	163	190	217	272	312	392	432	577	617																
10.0	25.0	40.6	53.8	83.5	116	147	162	193	222	252	309	352	437	479	631	672																
5.0	31.2	47.1	60.0	96.9	131	164	180	212	243	274	334	378	465	509	665	707																
1.0	43.8	59.0	70.7	126	164	200	218	252	285	318	382	429	522	568	732	776																
	2.5	10	X	25	40	X	65	X	100	X	150	X	250	X	400	X																

**Notes:** Binomial distribution used for percent defective comparisons; Poissons for defects per hundred units

TABLE X-D-2 - SAMPLING PLANS FOR SAMPLE SIZE CODE LETTER: D

Type of sampling plan	Consecutive sample size	Acceptable Quality Levels (normal inspection)																	Commutative sample size
		Less than 1.5	1.5	2.5	4.0	6.5	10	15	25	40	65	100	150	250	400	Higher than 400			
		Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re		
Single	8	▽	0 1															△	8
Double	5	▽	•															△	5
	10																		10
Multiple	2	▽	•															△	2
	4																		4
	6																		6
	8																		8
	10																		10
	12																		12
	14																		14
		Less than 2.5	2.5	4.0	6.5	10	15	25	40	65	100	150	250	400	Higher than 400				
Acceptable Quality Levels (tightened inspection)																			

△ = Use next preceding sample size code letter for which acceptance and rejection numbers are available.

▽ = Use next subsequent sample size code letter for which acceptance and rejection numbers are available.

Ac = Acceptance number

Re = Rejection number

• = Use single sampling plan above (or alternatively use code letter G)

• = Acceptance not permitted at this sample size.

TABLE X-E—Tables for sample size code letter: E

CHART E - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS  
(Curves for double and multiple sampling are matched as closely as practicable)

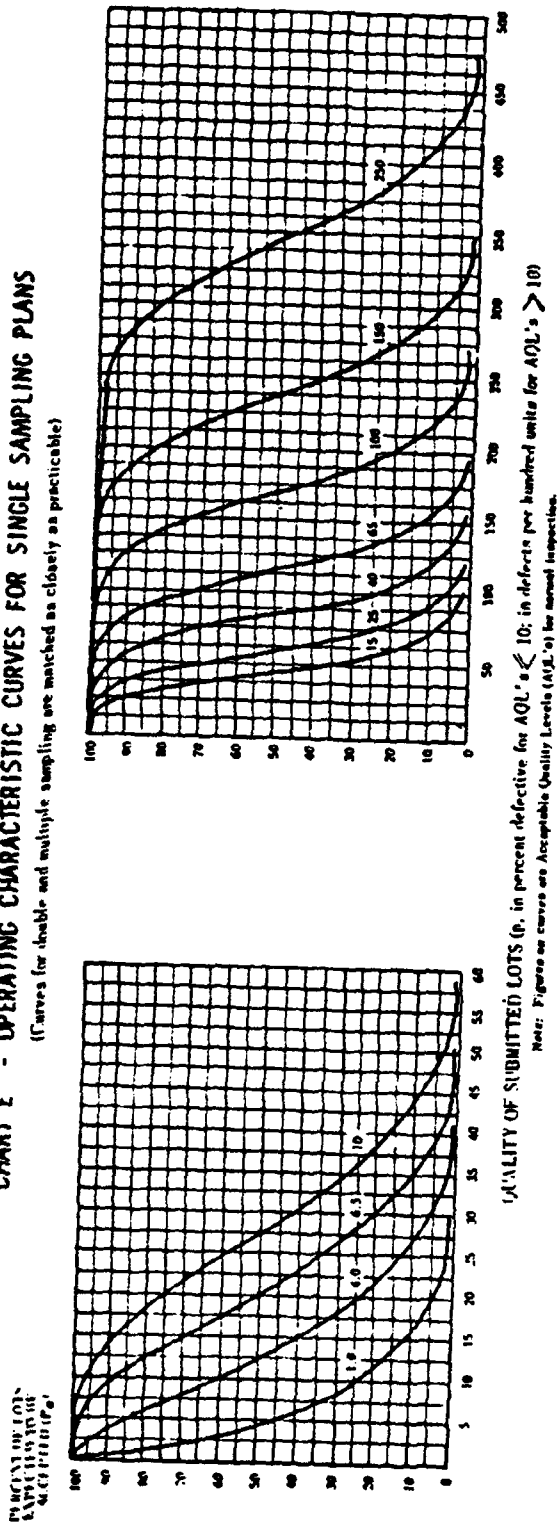


TABLE X-E-1 - TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

P <sub>o</sub>	Acceptable Quality Levels (normal inspection)															Acceptable Quality Levels (tightened inspection)														
	p (in percent defective)					p (in defects per hundred units)										p (in percent defective)					p (in defects per hundred units)									
	1.0	4.0	6.5	10	15	1.0	4.0	6.5	10	15	25	40	65	100	150	250	400	650	1000	1.0	4.0	6.5	10	15	25	40	65	100	150	250
99.0	0.077	1.18	3.58	6.75	11.3	0.077	1.15	3.35	6.33	13.7	22.4	36.7	46.9	57.5	79.6	96.7	132	150	219	238	238	238	238	238	238	238	238	238	238	238
95.0	0.394	2.81	6.60	11.3	16.9	0.394	2.73	6.29	10.5	20.1	30.6	47.5	59.2	71.1	95.7	115	153	173	246	266	266	266	266	266	266	266	266	266	266	266
90.0	0.807	4.17	8.80	14.2	22.4	0.810	4.09	8.48	13.4	24.2	35.8	54.0	66.5	79.2	105	125	165	185	261	282	282	282	282	282	282	282	282	282	282	282
75.0	2.19	7.41	13.4	19.9	32.5	2.21	7.39	13.3	19.5	32.5	45.8	66.3	80.2	94.1	122	144	187	208	288	310	310	310	310	310	310	310	310	310	310	310
50.0	5.19	12.6	20.0	27.5	43.6	5.33	12.9	20.6	28.2	43.6	59.0	82.1	97.4	113	144	167	213	236	321	344	344	344	344	344	344	344	344	344	344	344
25.0	10.1	19.4	28.0	36.1	57.1	10.7	20.7	30.2	39.3	57.1	74.5	100	117	134	167	192	241	266	355	379	379	379	379	379	379	379	379	379	379	379
10.0	16.2	26.8	36.0	44.4	71.3	17.7	29.9	40.9	51.4	71.3	90.5	119	137	155	190	217	269	295	380	414	414	414	414	414	414	414	414	414	414	414
5.0	20.6	31.6	41.0	49.5	80.9	23.0	36.5	48.4	59.6	80.9	101	130	150	168	205	233	286	313	409	435	435	435	435	435	435	435	435	435	435	435
1.0	29.8	41.3	50.6	58.8	90.9	35.4	51.1	64.7	77.3	101	123	155	176	196	235	264	321	349	450	477	477	477	477	477	477	477	477	477	477	477
1.5	6.5	10	15	25	40	1.5	6.5	10	15	25	40	65	100	150	250	400	650	1000	1500	2500	4000	6500	10000	15000	25000	40000	65000	100000	150000	250000

Note: Binomial distribution used for percent defective computations. (Please use for defects per hundred units.)

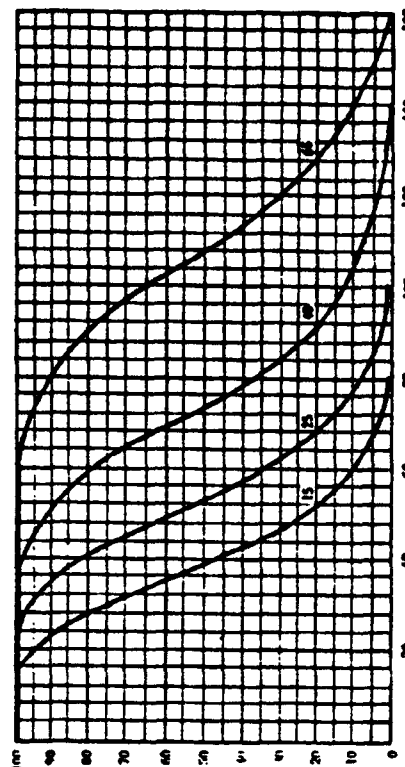
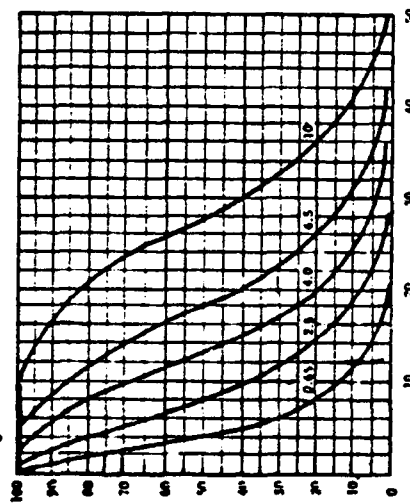
$\Delta$	=	Use set preceding sample size code letter for which acceptance and rejection numbers are available.
$\nabla$	=	Use set subsequent sample size code letter for which acceptance and rejection numbers are available.
Ac	=	Acceptance number.
Re	=	Rejection number.
$\phi$	=	Use single sampling plan above (or alternatively use code letter H)
$\phi$	=	Acceptance not permitted at this sample size.



TABLE X-F—Tables for sample size code letter: F

CHART F - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

(Curves for double and multiple sampling are matched as closely as practicable)

PERCENT OF LOTS  
EXPOSED TO RE-  
ACCEPTED ( $P_a$ )QUALITY OF SUBMITTED LOTS ( $p$ , in percent defective for AQL's  $\leq 10$ ; in defects per hundred units for AQL's  $> 10$ )

Note: Figures on curves are Acceptable Quality Levels (AQL's) for normal inspection.

TABLE X-F-1 - TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

Acceptable Quality Levels (normal inspection)									
$p$ (in percent defective)									
$P_a$	0.65	2.5	4.0	6.5	10	0.65	2.5	4.0	6.5
99.0	0.0502	0.759	2.27	4.36	9.75	0.0503	0.743	2.1	4.0
95.0	0.256	1.81	4.22	7.14	14.0	0.256	1.70	4.0	6.5
90.0	0.525	2.69	5.64	9.03	16.6	0.527	2.66	5.6	9.0
75.0	1.43	4.81	8.70	12.8	21.6	1.44	4.81	8.6	13.4
50.0	3.41	6.25	13.1	18.1	27.9	3.47	6.39	13.4	19.6
25.0	6.70	12.9	18.7	24.2	34.8	6.93	13.5	19.6	26.6
10.0	10.9	18.1	24.5	30.4	41.5	11.5	19.4	26.6	34.8
5.0	13.9	21.6	28.3	34.4	45.6	15.0	23.7	34.8	42.0
1.0	20.6	28.9	35.8	42.1	53.2	23.0	33.2	42.0	50.0
	1.0	4.0	6.5	10	X	1.0	4.0	6.5	10
Acceptable									

Acceptable Quality Levels (normal inspection)									
$p$ (in defects per hundred units)									
$r$ Levels (tightened inspection)	6.5	10	15	25	40	65	10	15	25
4.12	8.93	14.5	17.5	23.9	30.5	37.4	51.7	62.9	74.5
6.83	13.1	19.9	23.5	30.8	38.4	46.2	62.2	74.5	81.2
8.72	15.8	23.3	27.2	35.1	43.2	51.5	68.4	81.2	93.4
12.7	21.1	29.8	34.2	43.1	52.1	61.2	79.5	93.4	108
18.4	28.4	38.3	43.3	53.3	63.3	73.3	93.3	108	125
25.5	37.1	48.4	54.8	65.1	76.1	87.0	109	125	141
33.4	46.4	58.9	65.0	77.0	88.9	101	124	141	151
38.8	52.6	65.7	72.2	84.8	97.2	109	133	151	172
50.2	65.5	80.0	87.0	101	114	127	153	172	X
10	15	X	25	X	40	X	65	X	X
Rejection									

Rejection (tightened inspection)

Note: Figures on curves are Acceptable Quality Levels (AQL's) for normal inspection.

$\Delta$	=	Use next preceding sample size code letter for which acceptance and rejection numbers are available.
$\nabla$	=	Use next subsequent sample size code letter for which acceptance and rejection numbers are available.
Ac	=	Acceptance number
Re	=	Rejection number
•	=	Use single sampling plan above (or alternatively use code letter J)
a	=	Acceptance not permitted at this sample size.

TABLE X-G—Tables for sample size code letter: G

CHART G - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS  
(Curves for double and multiple sampling are matched as closely as practicable)

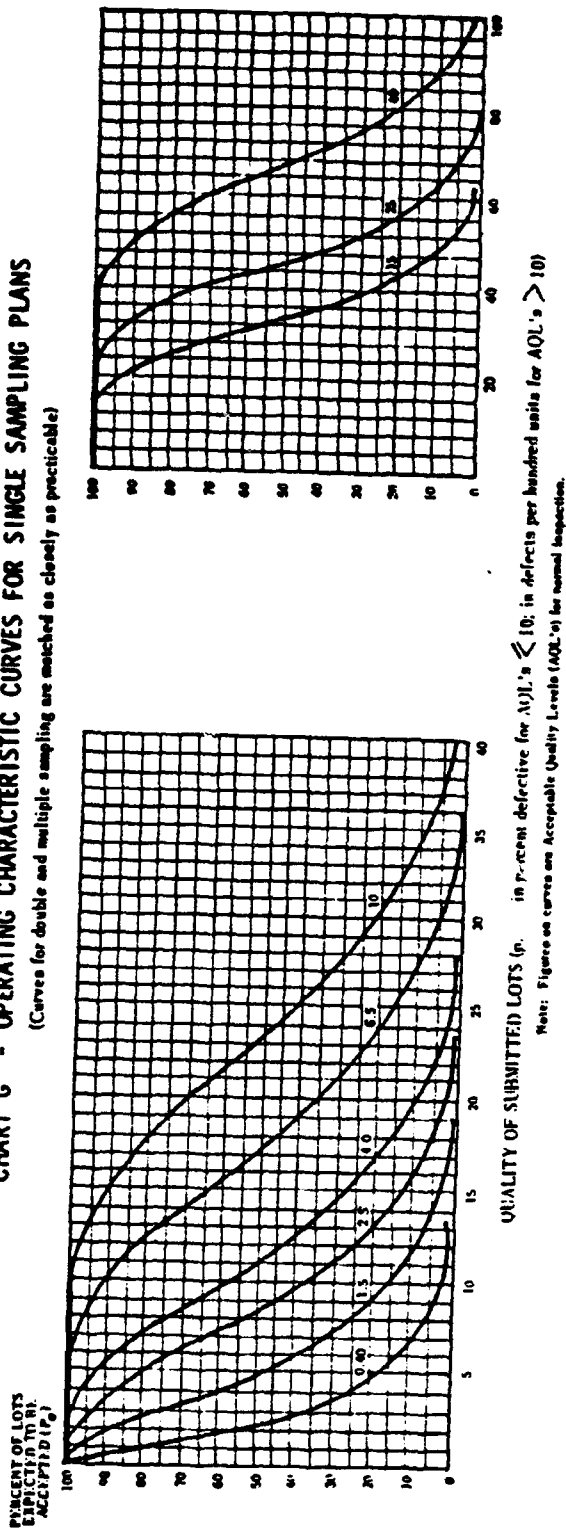


TABLE X-G-1 - TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

P <sub>o</sub>	Acceptable Quality Levels (normal inspection)																Acceptable Quality Levels (tightened inspection)															
	p (in percent defective)										p (in defects per hundred units)																					
	0.40	1.5	2.5	4.0	6.5	10	10	15	25	40	0.40	1.5	2.5	4.0	6.5	10	10	15	25	40	0.40	1.5	2.5	4.0	6.5	10	10	15	25	40		
99.0	0.0314	0.471	1.40	2.67	5.88	9.73	9.73	13.1	13.1	13.1	0.0314	0.464	1.36	2.57	5.58	9.08	11.0	14.9	19.1	23.4	32.3	39.3										
95.0	0.160	1.12	2.60	4.38	8.50	13.1	13.1	15.1	15.1	15.1	0.160	1.11	2.58	4.27	8.17	12.4	14.7	19.3	24.0	28.9	38.9	46.5										
90.0	0.329	1.67	3.49	5.56	10.2	15.1	15.1	17.5	17.5	17.5	0.329	1.66	3.44	5.45	9.85	14.6	17.0	21.9	27.0	32.2	42.7	50.8										
75.0	0.895	3.01	5.42	7.98	13.4	19.0	19.0	23.7	23.7	23.7	0.899	3.00	5.40	7.92	13.2	18.6	21.4	26.9	32.6	38.2	49.7	58.4										
50.0	2.14	5.19	8.27	11.4	17.5	23.7	23.7	29.0	29.0	29.0	2.17	5.24	8.36	11.5	17.7	24.0	27.1	33.3	39.6	45.8	58.3	67.7										
25.0	4.24	8.19	11.9	15.4	22.3	29.0	29.0	34.1	34.1	34.1	4.33	8.41	12.3	16.0	23.2	30.3	33.8	40.7	47.6	54.4	67.9	78.0										
10.0	6.94	11.6	15.8	19.7	27.1	34.1	34.1	37.2	37.2	37.2	7.20	12.2	16.6	20.9	29.0	36.8	40.6	48.1	55.6	62.9	77.4	88.1										
5.0	8.94	14.0	18.4	22.5	30.1	37.2	37.2	39.6	39.6	39.6	9.36	14.8	19.7	24.2	32.9	41.1	45.1	53.0	60.8	68.4	83.4	94.5										
1.0	13.4	19.0	23.8	28.1	36.0	43.2	43.2	44.4	44.4	44.4	14.4	20.7	26.3	31.4	41.0	50.0	54.4	63.0	71.3	79.5	95.6	107										
0.65	2.5	4.0	6.5	10	10	10	10	10	10	10	0.65	2.5	4.0	6.5	10	10	15	15	25	25	40	40										

Note: Binomial distribution used for percent defective computations; Poisson for defects per hundred units.

TABLE X-G-2 - SAMPLING PLANS FOR SAMPLE SIZE CODE LETTER: G

Type of sampling plan	Cumulative sample size	Acceptable Quality Levels (normal inspection)																														Cumulative sample size																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																													
		Less than 0.40	0.40		0.65		1.0	1.5		2.5		4.0		6.5		10		15		25		40		Higher than 40																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																					
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△ = Use next preceding sample size code letter for which acceptance and rejection numbers are available.

▽ = Use next subsequent sample size code letter for which acceptance and rejection numbers are available.

Ac = Acceptance number.

Re = Rejection number.

• = Use single sampling plan above (or alternatively use code letter K)

• = Acceptance not permitted at this sample size.

TABLE X-H—Tables for sample size code letter: H

CHART H - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS  
(Curves for double and multiple sampling are matched as closely as practicable)

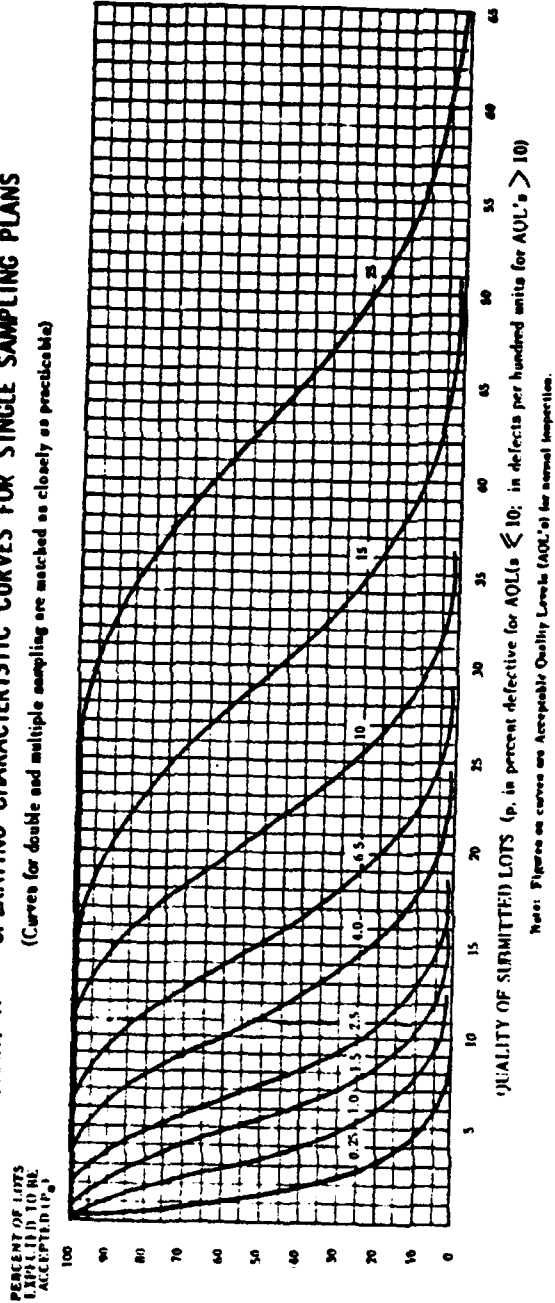


TABLE X-H-1 - TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

P <sub>d</sub>	Acceptable Quality Levels (normal inspection)																			
	0.25	1.0	1.5	2.5	4.0	6.5	10	15	25	40	65	100	150	200	250	300	350	400	450	
	p (in percent defective)																			
99.0	0.0201	0.300	0.486	1.68	3.69	6.07	7.36	10.1	0.0201	0.297	0.872	1.65	3.57	5.81	7.01	9.54	12.2	15.0	20.7	25.1
95.0	0.103	0.715	1.66	2.78	5.36	8.22	9.72	12.9	0.103	0.711	1.64	2.73	5.23	7.96	9.39	12.3	15.4	18.5	24.9	29.8
90.0	0.210	1.07	2.22	3.53	6.43	9.54	11.2	14.5	0.211	1.06	2.20	3.49	6.30	9.31	10.9	14.0	17.3	20.6	27.3	32.5
75.0	0.574	1.92	3.46	5.10	8.51	12.0	13.8	17.5	0.575	1.92	3.45	5.07	8.44	11.9	13.7	17.2	20.8	24.5	31.8	37.4
50.0	1.38	3.33	5.31	7.29	11.3	15.2	17.2	21.2	1.39	3.36	5.35	7.34	11.3	15.3	17.3	21.3	25.3	29.3	37.3	43.3
25.0	2.73	5.29	7.69	10.0	14.5	18.6	21.0	25.2	2.77	5.39	7.84	10.2	14.8	19.4	21.6	26.0	30.4	34.8	43.5	49.9
10.0	4.50	7.56	10.3	12.9	17.8	22.4	24.7	29.1	4.61	7.78	10.6	13.4	18.5	23.5	26.0	30.8	35.6	40.3	49.5	56.4
5.0	5.82	9.14	12.1	14.8	19.9	24.7	27.0	31.6	5.99	9.49	12.6	15.5	21.0	26.3	28.9	33.9	38.9	43.8	53.4	60.5
1.0	8.00	12.6	15.8	18.7	24.2	29.2	31.7	36.3	9.21	13.3	16.8	20.1	26.2	32.0	34.8	40.3	45.6	50.9	61.2	68.7
0.40	1.5	2.5	4.0	6.5	10	15	20	25	0.40	1.5	2.5	4.0	6.5	10	15	20	25	30	35	40
	Acceptable Quality Levels (lightened inspection)																			
	0.40	0.65	1.0	1.5	2.5	4.0	6.5	10	15	20	25	30	35	40	45	50	55	60	65	70

Note: Binomial distribution used for percent defective comparisons; Poisson for defects per hundred units.

TABLE X-H-2 - SAMPLING PLANS FOR SAMPLE SIZE CODE LETTER: H

Type of sampling plan	Cumulative sample size	Acceptable Quality Levels (normal inspection)																		Cumulative sample size	
		Less than 0.25	0.25	0.40	0.65	1.0	1.5	2.5	4.0	6.5	10	15	25	Higher than 25							
		Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re		
		Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re		
Single	50	▽	0 1																	50	
	32 64	▽	•																	32 64	
Multiple	13	▽	•																	13	
	26																			26	
	39																			39	
	52																			52	
	65																			65	
	78																			78	
	91																			91	
		Less than 0.40	0.40	0.65	1.0	1.5	2.5	4.0	6.5	10	15	25	Higher than 25								

Acceptable Quality Levels (tightened inspection)

△ = Use next preceding sample size code letter for which acceptance and rejection numbers are available.

▽ = Use next subsequent sample size code letter for which acceptance and rejection numbers are available.

Ac = Acceptance number

Re = Rejection number

• = Use single sampling plan above (or alternatively use code letter L)

• = Acceptance not permitted at this sample size

Note: Binomial distribution used for percent defective computations; Poissons for defects per hundred units.

TABLE X-J-2 - SAMPLING PLANS FOR SAMPLE SIZE CODE LETTER: J

Type of sampling plan	Cumulative sample size	Acceptable Quality Levels (normal inspection)																	Cumulative sample size																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																											
		Less than 0.15	0.15	0.25	0.40	0.65	1.0	1.5	2.5	4.0	6.5	10	15	Higher than 15																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																
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271	272 273	274 275	276 277	278 279	280 281	282 283	284 285	286 287	288 289	290 291	292 293	294 295	296 297	298 299	300 301	302 303	304 305	306 307	308 309	310 311	312 313	314 315	316 317	318 319	320 321	322 323	324 325	326 327	328 329	330 331	332 333	334 335	336 337	338 339	340 341	342 343	344 345	346 347	348 349	350 351	352 353	354 355	356 357	358 359	360 361	362 363	364 365	366 367	368 369	370 371	372 373	374 375	376 377	378 379	380 381	382 383	384 385	386 387	388 389	390 391	392 393	394 395	396 397	398 399	400 401	402 403	404 405	406 407	408 409	410 411	412 413	414 415	416 417	418 419	420 421	422 423	424 425	426 427	428 429	430 431	432 433	434 435	436 437	438 439	440 441	442 443	444 445	446 447	448 449	450 451	452 453	454 455	456 457	458 459	460 461	462 463	464 465	466 467	468 469	470 471	472 473	474 475	476 477	478 479	480 481	482 483	484 485	486 487	488 489	490 491	492 493	494 495	496 497	498 499	500 501	502 503	504 505	506 507	508 509	510 511	512 513	514 515	516 517	518 519	520 521	522 523	524 525	526 527	528 529	530 531	532 533	534 535	536 537	538 539	540 541	542 543	544 545	546 547	548 549	550 551	552 553	554 555	556 557	558 559	560 561	562 563	564 565	566 567	568 569	570 571	572 573	574 575	576 577	578 579	580 581	582 583	584 585	586 587	588 589	590 591	592 593	594 595	596 597	598 599	600 601	602 603	604 605	606 607	608 609	610 611	612 613	614 615	616 617	618 619	620 621	622 623	624 625	626 627	628 629	630 631	632 633	634 635	636 637	638 639	640 641	642 643	644 645	646 647	648 649	650 651	652 653	654 655	656 657	658 659	660 661	662 663	664 665	666 667	668 669	670 671	672 673	674 675	676 677	678 679	680 681	682 683	684 685	686 687	688 689	690 691	692 693	694 695	696 697	698 699	700 701	702 703	704 705	706 707	708 709	710 711	712 713	714 715	716 717	718 719	720 721	722 723	724 725	726 727	728 729	730 731	732 733	734 735	736 737	738 739	740 741	742 743	744 745	746 747	748 749	750 751	752 753	754 755	756 757	758 759	760 761	762 763	764 765	766 767	768 769	770 771	772 773	774 775	776 777	778 779	780 781	782 783	784 785	786 787	788 789	790 791	792 793	794 795	796 797	798 799	800 801	802 803	804 805	806 807	808 809	810 811	812 813	814 815	816 817	818 819	820 821	822 823	824 825	826 827	828 829	830 831	832 833	834 835	836 837	838 839	840 841	842 843	844 845	846 847	848 849	850 851	852 853	854 855	856 857	858 859	860 861	862 863	864 865	866 867	868 869	870 871	872 873	874 875	876 877	878 879	880 881	882 883	884 885	886 887	888 889	890 891	892 893	894 895	896 897	898 899	900 901	902 903	904 905	906 907	908 909	910 911	912 913	914 915	916 917	918 919	920 921	922 923	924 925	926 927	928 929	930 931	932 933	934 935	936 937	938 939	940 941	942 943	944 945	946 947	948 949	950 951	952 953	954 955	956 957	958 959	960 961	962 963	964 965	966 967	968 969	970 971	972 973	974 975	976 977	978 979	980 981	982 983	984 985	986 987	988 989	990 991	992 993	994 995	996 997	998 999	1000 1001	1002 1003	1004 1005	1006 1007	1008 1009	1010 1011	1012 1013	1014 1015	1016 1017	1018 1019	1020 1021	1022 1023	1024 1025	1026 1027	1028 1029	1030 1031	1032 1033	1034 1035	1036 1037	1038 1039	1040 1041	1042 1043	1044 1045	1046 1047	1048 1049	1050 1051	1052 1053	1054 1055	1056 1057	1058 1059	1060 1061	1062 1063	1064 1065	1066 1067	1068 1069	1070 1071	1072 1073	1074 1075	1076 1077	1078 1079	1080 1081	1082 1083	1084 1085	1086 1087	1088 1089	1090 1091	1092 1093	1094 1095	1096 1097	1098 1099	1100 1101	1102 1103	1104 1105	1106 1107	1108 1109	1110 1111	1112 1113	1114 1115	1116 1117	1118 1119	1120 1121	1122 1123	1124 1125	1126 1127	1128 1129	1130 1131	1132 1133	1134 1135	1136 1137	1138 1139	1140 1141	1142 1143	1144 1145	1146 1147	1148 1149	1150 1151	1152 1153	1154 1155	1156 1157	1158 1159	1160 1161	1162 1163	1164 1165	1166 1167	1168 1169	1170 1171	1172 1173	1174 1175	1176 1177	1178 1179	1180 1181	1182 1183	1184 1185	1186 1187	1188 1189	1190 1191	1192 1193	1194 1195	1196 1197	1198 1199	1200 1201	1202 1203	1204 1205	1206 1207	1208 1209	1210 1211	1212 1213	1214 1215	1216 1217	1218 1219	1220 1221	1222 1223	1224 1225	1226 1227	1228 1229	1230 1231	1232 1233	1234 1235	1236 1237	1238 1239	1240 1241	1242 1243	1244 1245	1246 1247	1248 1249	1250 1251	1252 1253	1254 1255	1256 1257	1258 1259	1260 1261	1262 1263	1264 1265	1266 1267	1268 1269	1270 1271	1272 1273	1274 1275	1276 1277	1278 1279	1280 1281	1282 1283	1284 1285	1286 1287	1288 1289	1290 1291	1292 1293	1294 1295	1296 1297	1298 1299	1300 1301	1302 1303	1304 1305	1306 1307	1308 1309	1310 1311	1312 1313	1314 1315	1316 1317	1318 1319	1320 1321	1322 1323	1324 1325	1326 1327	1328 1329	1330 1331	1332 1333	1334 1335	1336 1337	1338 1339	1340 1341	1342 1343	1344 1345	1346 1347	1348 1349	1350 1351	1352 1353	1354 1355	1356 1357	1358 1359	1360 1361	1362 1363	1364 1365	1366 1367	1368 1369	1370 1371	1372 1373	1374 1375	1376 1377	1378 1379	1380 1381	1382 1383	1384 1385	1386 1387	1388 1389	1390 1391	1392 1393	1394 1395	1396 1397	1398 1399	1400 1401	1402 1403	1404 1405	1406 1407	1408 1409	1410 1411	1412 1413	1414 1415	1416 1417	1418 1419	1420 1421	1422 1423	1424 1425	1426 1427	1428 1429	1430 1431	1432 1433	1434 1435	1436 1437	1438 1439	1440 1441	1442 1443	1444 1445	1446 1447	1448 1449	1450 1451	1452 1453	1454 1455	1456 1457	1458 1459	1460 1461	1462 1463	1464 1465	1466 1467	1468 1469	1470 1471	1472 1473	1474 1475	1476 1477	1478 1479	1480 1481	1482 1483	1484 1485	1486 1487	1488 1489	1490 1491	1492 1493	1494 1495	1496 1497	1498 1499	1500 1501	1502 1503	1504 1505	1506 1507	1508 1509	1510 1511	1512 1513	1514 1515	1516 1517	1518 1519	1520 1521	1522 1523	1524 1525	1526 1527	1528 1529	1530 1531	1532 1533	1534 1535	1536 1537	1538 1539	1540 1541	1542 1543	1544 1545	1546 1547	1548 1549	1550 1551	1552 1553	1554 1555	1556 1557	1558 1559	1560 1561	1562 1563	1564 1565	1566 1567	1568 1569	1570 1571	1572 1573	1574 1575	1576 1577	1578 1579	1580 1581	1582 1583	1584 1585	1586 1587	1588 1589	1590 1591	1592 1593	1594 1595	1596 1597	1598 1599	1600 1601	1602 1603	1604 1605	1606 1607	1608 1609	1610 1611	1612 1613	1614 1615	1616 1617	1618 1619	1620 1621	1622 1623	1624 1625	1626 1627	1628 1629	1630 1631	1632 1633	1634 1635	1636 1637	1638 1639	1640 1641	1642 1643	1644 1645	1646 1647	1648 1649	1650 1651	1652 1653	1654 1655	1656 1657	1658 1659	1660 1661	1662 1663	1664 1665	1666 1667	1668 1669	1670 1671	1672 1673	1674 1675	1676 1677	1678 1679	1680 1681	1682 1683	1684 1685	1686 1687	1688 1689	1690 1691	1692 1693	1694 1695	1696 1697	1698 1699	1700 1701	1702 1703	1704 1705	1706 1707	1708 1709	1710 1711	1712 1713	1714 1715	1716 1717	1718 1719	1720 1721	1722 1723	1724 1725	1726 1727	1728 1729	1730 1731	1732 1733	1734 1735	1736 1737	1738 1739	1740 1741	1742 1743	1744 1745	1746 1747	1748 1749	1750 1751	1752 1753	1754 1755	1756 1757	1758 1759	1760 1761	1762 1763	1764 1765	1766 1767	1768 1769	1770 1771	1772 1773	1774 1775	1776 1777	1778 1779	1780 1781	1782 1783	1784 1785	1786 1787	1788 1789	1790 1791	1792 1793	1794 1795	1796 1797	1798 1799	1800 1801	1802 1803	1804 1805	1806 1807	1808 1809	1810 1811	1812 1813	1814 1815	1816 1817	1818 1819	1820 1821	1822 1823	1824 1825	1826 1827	1828 1829	1830 1831	1832 1833	1834 1835	1836 1837	1838 1839	1840 1841	1842 1843	1844 1845	1846 1847	1848 1849	1850 1851	1852 1853	1854 1855	1856 1857	1858 1859	1860 1861	1862 1863	1864 1865	1866 1867	1868 1869	1870 1871

△ Use next preceding sample size code letter for which acceptance and rejection numbers are available.

▽ Use next subsequent sample size code letter for which acceptance and rejection numbers are available.

Ac Acceptance number

Re Rejection number

• Use single sampling plan above (or alternatively use code letter M)

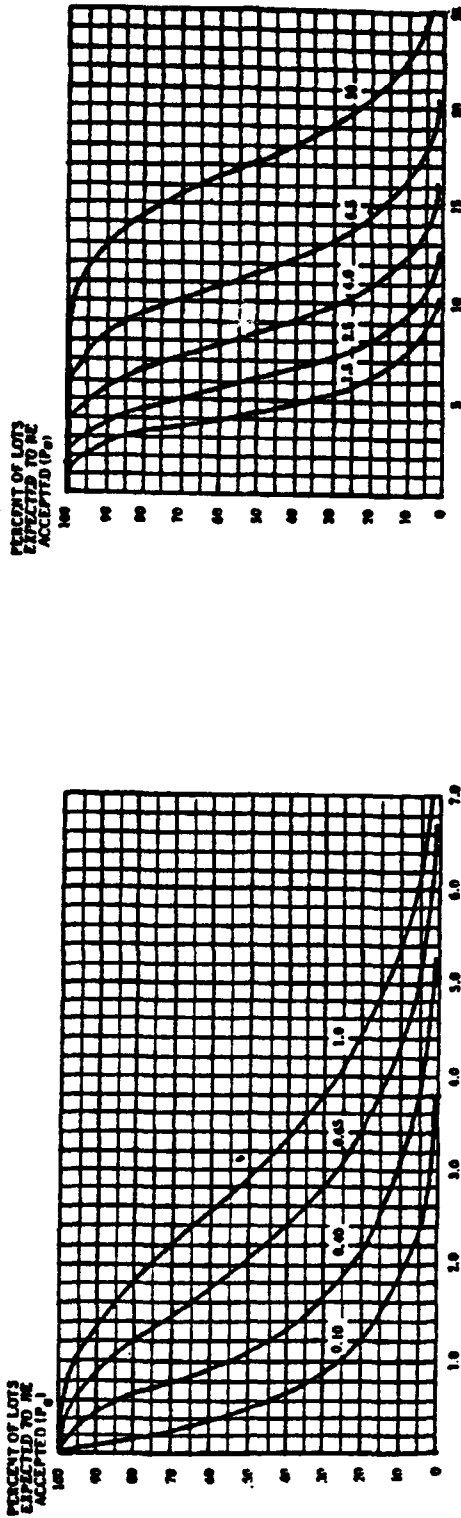
• Acceptance not permitted at this sample size.



TABLE X-K—Tables for sample size code letter: K

CHART K - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

(Curves for double and multiple sampling are matched as closely as practicable)



Notes: Figures on curves are Acceptable Quality Levels (AQL's) for normal inspection.

TABLE X-K-1 - TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

P <sub>o</sub>	Acceptable Quality Levels (normal inspection)									
	0.10	0.40	0.65	1.0	1.5	2.5	4.0	6.5	10	10
	p (in percent defective or defects per hundred units)									
99.0	0.00004	0.119	0.349	0.659	1.43	2.32	2.81	3.82	4.88	5.98
95.0	0.0410	0.284	0.654	1.09	2.09	3.16	3.76	4.94	6.15	7.40
90.0	0.0843	0.425	0.882	1.40	2.52	3.72	4.35	5.62	6.92	8.24
75.0	0.230	0.769	1.302	2.03	3.38	4.76	5.47	6.90	8.34	9.79
50.0	0.555	1.34	2.14	2.94	4.54	6.14	6.94	8.53	10.1	11.7
25.0	1.11	2.15	3.14	4.09	5.94	7.75	8.64	10.4	12.2	13.9
10.0	1.84	3.11	4.26	5.34	7.42	9.42	10.4	12.3	14.2	16.1
5.0	2.40	3.80	5.04	6.20	8.41	10.5	11.5	13.6	15.6	17.5
1.0	3.68	5.31	6.72	8.04	10.5	12.8	13.3	16.1	18.3	20.4
	0.15	0.65	1.0	1.5	2.5	4.0	6.5	10	10	10
	Acceptable Quality Levels (tightened inspection)									

Notes: All values given in above table based on Poisson distribution as an approximation to the Binomial.

TABLE X-K-2 - SAMPLING PLANS FOR SAMPLE SIZE CODE LETTER: K

Type of sampling plan	Cumulative sample size	Acceptable Quality Levels (normal inspection)																													
		Less than 0.10		0.10	0.15	0.25		0.40	0.65	1.0	1.5	2.5	4.0		6.5	10		Higher than 10													
		Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re										
		Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re										
Single	125	▽	0	1																										△	125
Double	80	▽	•																											△	80
	160																														160
Multiple	32	▽	•																											△	32
	64																														64
	96																														96
	128																														128
	160																														160
	192																														192
	224																														224
		Less than 0.15	0.15	0.25	0.40	0.65	1.0	1.5	2.5	4.0	6.5	10	Higher than 10																		
Acceptable Quality Levels (tightened inspection)																															

△ = Use next preceding sample size code letter for which acceptance and rejection numbers are available.

▽ = Use next subsequent sample size code letter for which acceptance and rejection numbers are available.

Ac = Acceptance number

Re = Rejection number

• = Use single sampling plan above (or alternatively use code letter H)

• = Acceptance not permitted at this sample size.

TABLE X-L—Tables for sample size code letter: L

CHART L - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

(Curves for double and multiple sampling are matched as closely as practicable)

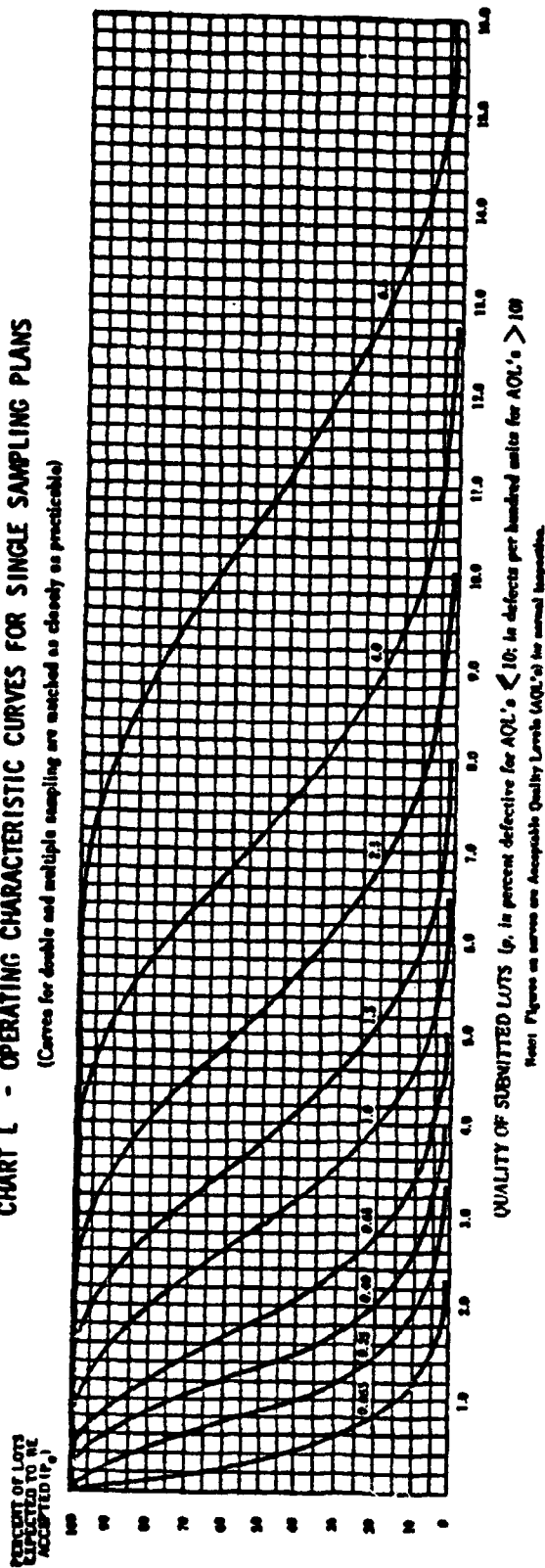


TABLE X-L-1 - TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

$P_a$	Acceptable Quality Levels (normal inspection)									
	0.065	0.25	0.40	0.65	1.0	1.5	2.5	4.0	6.5	10.0
$p$ (in percent defective or defects per hundred units)										
99.0	0.00503	0.075	0.218	0.412	0.693	1.45	1.75	2.39	3.76	5.17
95.0	0.0256	0.178	0.409	0.683	1.31	1.99	2.35	3.08	4.62	6.22
90.0	0.0527	0.266	0.551	0.872	1.59	2.33	2.72	3.51	5.15	6.94
75.0	0.144	0.481	0.864	1.27	2.11	2.98	3.42	4.31	6.12	7.95
50.0	0.347	0.839	1.34	1.84	2.84	3.84	4.33	5.33	7.33	9.34
25.0	0.693	1.35	1.96	2.55	3.71	4.83	5.40	6.51	7.61	9.30
10.0	1.15	1.94	2.66	3.34	4.64	5.89	6.50	7.70	8.89	10.9
5.0	1.50	2.37	3.15	3.88	5.26	6.57	7.22	8.48	9.72	12.4
1.0	2.30	3.32	4.20	5.02	6.55	8.00	8.70	10.1	11.4	13.3
0.10	0.40	0.65	1.0	1.5	2.5	4.0	6.5	10.0	15.0	20.0
Acceptable Quality Levels (tightened inspection)										
99.0	0.00503	0.075	0.218	0.412	0.693	1.45	1.75	2.39	3.76	5.17
95.0	0.0256	0.178	0.409	0.683	1.31	1.99	2.35	3.08	4.62	6.22
90.0	0.0527	0.266	0.551	0.872	1.59	2.33	2.72	3.51	5.15	6.94
75.0	0.144	0.481	0.864	1.27	2.11	2.98	3.42	4.31	6.12	7.95
50.0	0.347	0.839	1.34	1.84	2.84	3.84	4.33	5.33	7.33	9.34
25.0	0.693	1.35	1.96	2.55	3.71	4.83	5.40	6.51	7.61	9.30
10.0	1.15	1.94	2.66	3.34	4.64	5.89	6.50	7.70	8.89	10.9
5.0	1.50	2.37	3.15	3.88	5.26	6.57	7.22	8.48	9.72	12.4
1.0	2.30	3.32	4.20	5.02	6.55	8.00	8.70	10.1	11.4	13.3
0.10	0.40	0.65	1.0	1.5	2.5	4.0	6.5	10.0	15.0	20.0

Note: All values given in above table based on Poisson distribution as an approximation to the Binomial.

TABLE X-L-2 - SAMPLING PLANS FOR SAMPLE SIZE CODE LETTER: L

•Type of sampling plan	Cumulative sample size	Acceptable Quality Levels (normal inspection)																Higher than 6.5
		Less than 0.065	0.065	0.10	0.15	0.25	0.40	0.65	1.0	1.5	2.5	4.0	6.5	Higher than 6.5				
Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re			
Single	200	▽	1													△	200	
Double	125	▽	•		Use code Letter											△	125	
	250			Use code Letter													250	
Multiple	50	▽	•													△	50	
	100																100	
	150																150	
	200																200	
	250																250	
	300																300	
	350																350	
		Less than 0.10	0.10	0.15	0.25	0.40	0.65	1.0	1.5	2.5	4.0	6.5	Higher than 6.5					
Acceptable Quality Levels (tightened inspection)																		

△ = Use next preceding sample size code letter for which acceptance and rejection numbers are available.

▽ = Use next subsequent sample size code letter for which acceptance and rejection numbers are available.

Ac = Acceptance number

Re = Rejection number

• = Use single sampling plan above (or alternatively use code letter P)

• = Acceptance not permitted at this sample size.

TABLE X-M—Tables for sample size code letter: M

CHART M - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

(Curves for double and multiple sampling are matched as closely as practicable)

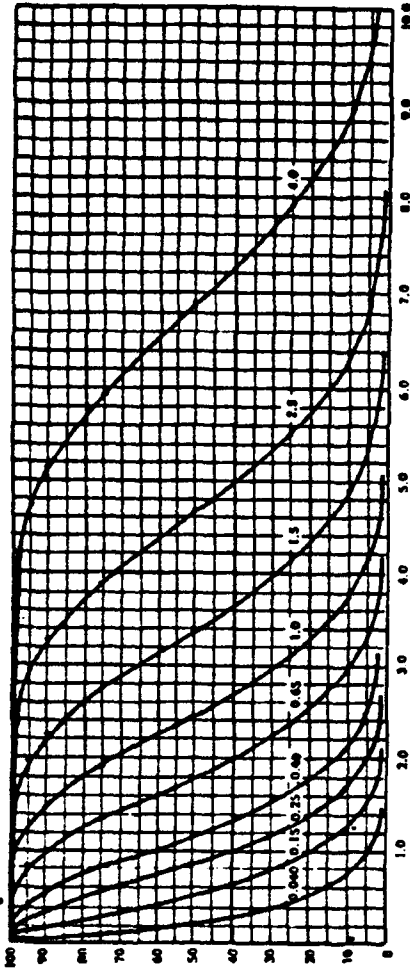
PERCENT OF LOTS  
EXPECTED TO BE  
ACCEPTED ( $P_a$ )QUALITY OF SUBMITTED LOTS ( $p$  in percent defective for AQL's  $\leq 10$ ; in defects per hundred units for AQL's  $> 10$ )  
Note: Figures on curves are Acceptable Quality Levels (AQL's) for normal inspection.

TABLE X-M-1 - TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

$P_a$	Acceptable Quality Levels (normal inspection)										
	0.040	0.15	0.25	0.40	0.65	1.0	1.5	2.5	4.0	6.0	10.0
	$p$ (in percent defective or in defects per hundred units)										
99.0	0.00219	0.0472	0.134	0.261	0.567	0.923	1.11	1.51	1.94	2.37	3.99
95.0	0.0163	0.113	0.260	0.434	0.830	1.26	1.49	1.96	2.44	2.94	4.73
90.0	0.0335	0.169	0.350	0.534	1.00	1.48	1.72	2.23	2.74	3.27	5.16
75.0	0.0913	0.305	0.548	0.805	1.34	1.89	2.17	2.74	3.31	3.89	5.93
50.0	0.220	0.533	0.849	1.17	1.80	2.43	2.75	3.39	4.02	4.66	6.88
25.0	0.440	0.855	1.24	1.62	2.36	3.07	3.43	4.13	4.80	5.52	7.92
10.0	0.731	1.23	1.69	2.12	2.94	3.74	4.13	4.89	5.64	6.39	8.95
5.0	0.951	1.51	2.00	2.46	3.34	4.17	4.56	5.38	6.17	6.95	9.60
1.0	1.46	2.11	2.67	3.19	4.16	5.08	5.52	6.40	7.34	8.08	10.9
0.065	0.25	0.40	0.65	1.0	1.5	2.5	4.0	6.0	10.0	15.0	25.0
Acceptable Quality Levels (tightened inspection)											
99.0	0.00219	0.0472	0.134	0.261	0.567	0.923	1.11	1.51	1.94	2.37	3.99
95.0	0.0163	0.113	0.260	0.434	0.830	1.26	1.49	1.96	2.44	2.94	4.73
90.0	0.0335	0.169	0.350	0.534	1.00	1.48	1.72	2.23	2.74	3.27	5.16
75.0	0.0913	0.305	0.548	0.805	1.34	1.89	2.17	2.74	3.31	3.89	5.93
50.0	0.220	0.533	0.849	1.17	1.80	2.43	2.75	3.39	4.02	4.66	6.88
25.0	0.440	0.855	1.24	1.62	2.36	3.07	3.43	4.13	4.80	5.52	7.92
10.0	0.731	1.23	1.69	2.12	2.94	3.74	4.13	4.89	5.64	6.39	8.95
5.0	0.951	1.51	2.00	2.46	3.34	4.17	4.56	5.38	6.17	6.95	9.60
1.0	1.46	2.11	2.67	3.19	4.16	5.08	5.52	6.40	7.34	8.08	10.9
0.065	0.25	0.40	0.65	1.0	1.5	2.5	4.0	6.0	10.0	15.0	25.0

Note: All values given in above table based on Poisson distribution as an approximation to the Binomial.

TABLE X-M-2 - SAMPLING PLANS FOR SAMPLE SIZE CODE LETTER: M

Type of sampling plan	Cumulative sample size	Acceptable Quality Levels (normal inspection)																Cumulative sample size		
		Less than 0.040	0.040	0.065	0.10	0.15	0.25	0.40	0.65	1.0	1.5	2.5	4.0	Higher than 4.0						
		Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re					
Single	315	▽	0 1															△	315	
Double	200 400	▽	•															△	200 400	
Multiple	80 160 240 320 400 480 560	▽	•															△	80 160 240 320 400 480 560	
		Less than 0.065	0.065	0.10	0.15	0.25	0.40	0.65	1.0	1.5	2.5	4.0	Higher than 4.0							
Acceptable Quality Levels (tightened inspection)																				

△ = Use next preceding sample size code letter for which acceptance and rejection numbers are available.

▽ = Use next subsequent sample size code letter for which acceptance and rejection numbers are available.

Ac = Acceptance number.

Re = Rejection number.

• = Use single sampling plan above (or alternatively use code letter Q)

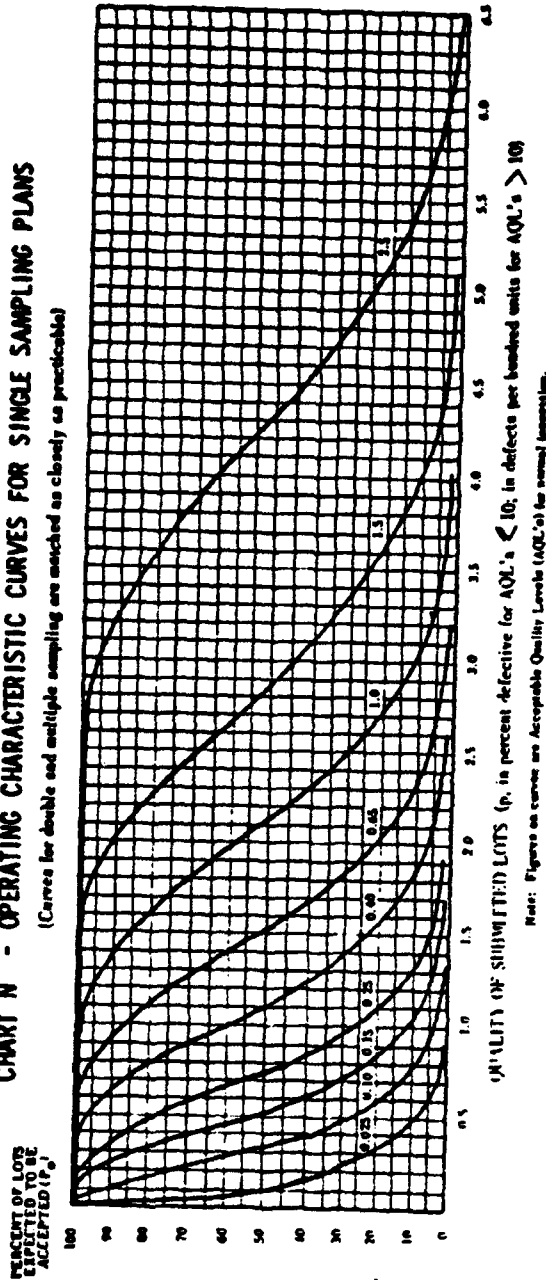
= Acceptance not permitted at this sample size.

M

TABLE X-N — Tables for sample size code letter: N

CHART N - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

(Curves for double and multiple sampling are marked as closely as practicable)



Note: Figures on curves are Acceptable Quality Levels (AQL's) for normal inspection.

TABLE X-N-1 - TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

P <sub>o</sub>	Acceptable Quality Levels (normal inspection)										
	0.025	0.10	0.15	0.25	0.40	0.65	1.0	1.5	2.5	5.0	10
	p (in percent defective or in defects per hundred units)										
99.0	0.00201	0.0097	0.0072	0.165	0.357	0.581	0.701	0.954	1.22	1.50	2.07
95.0	0.0103	0.0711	0.164	0.273	0.523	0.796	0.939	1.23	1.54	1.85	2.49
90.0	0.0211	0.106	0.220	0.349	0.630	0.931	1.09	1.40	1.73	2.06	2.73
75.0	0.0575	0.192	0.345	0.507	0.844	1.19	1.37	1.72	2.08	2.45	3.16
50.0	0.139	0.336	0.535	0.734	1.13	1.53	1.73	2.13	2.53	2.93	3.73
25.0	0.277	0.539	0.784	1.02	1.40	1.94	2.16	2.60	3.04	3.48	4.35
10.0	0.461	0.778	1.06	1.34	1.85	2.35	2.60	3.08	3.56	4.03	4.95
5.0	0.599	0.949	1.26	1.55	2.10	2.63	2.89	3.39	3.89	4.38	5.34
1.0	0.921	1.33	1.68	2.01	2.62	3.20	3.48	4.03	4.56	5.09	6.12
0.040	0.15	0.25	0.40	0.65	1.0	1.5	2.0	2.5	3.0	3.5	4.0
Acceptable Quality Levels (tightened inspection)											
99.0	0.00201	0.0097	0.0072	0.165	0.357	0.581	0.701	0.954	1.22	1.50	2.07
95.0	0.0103	0.0711	0.164	0.273	0.523	0.796	0.939	1.23	1.54	1.85	2.49
90.0	0.0211	0.106	0.220	0.349	0.630	0.931	1.09	1.40	1.73	2.06	2.73
75.0	0.0575	0.192	0.345	0.507	0.844	1.19	1.37	1.72	2.08	2.45	3.16
50.0	0.139	0.336	0.535	0.734	1.13	1.53	1.73	2.13	2.53	2.93	3.73
25.0	0.277	0.539	0.784	1.02	1.40	1.94	2.16	2.60	3.04	3.48	4.35
10.0	0.461	0.778	1.06	1.34	1.85	2.35	2.60	3.08	3.56	4.03	4.95
5.0	0.599	0.949	1.26	1.55	2.10	2.63	2.89	3.39	3.89	4.38	5.34
1.0	0.921	1.33	1.68	2.01	2.62	3.20	3.48	4.03	4.56	5.09	6.12
0.040	0.15	0.25	0.40	0.65	1.0	1.5	2.0	2.5	3.0	3.5	4.0

Note: All values given in above table based on Poisson distribution as an approximation to the Binomial.

TABLE X-N-2 - SAMPLING PLANS FOR SAMPLE SIZE CODE LETTER: N

Type of sampling plan	Cumulative sample size	Acceptable Quality Levels (normal inspection)																				Higher than 2.5																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																										
		Less than 0.025	0.025	0.040	0.065	0.10	0.15	0.25	0.40	0.65	1.0	1.5	2.5	Higher than 2.5																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																		
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Single	500	▽	0	1			1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	△																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																			

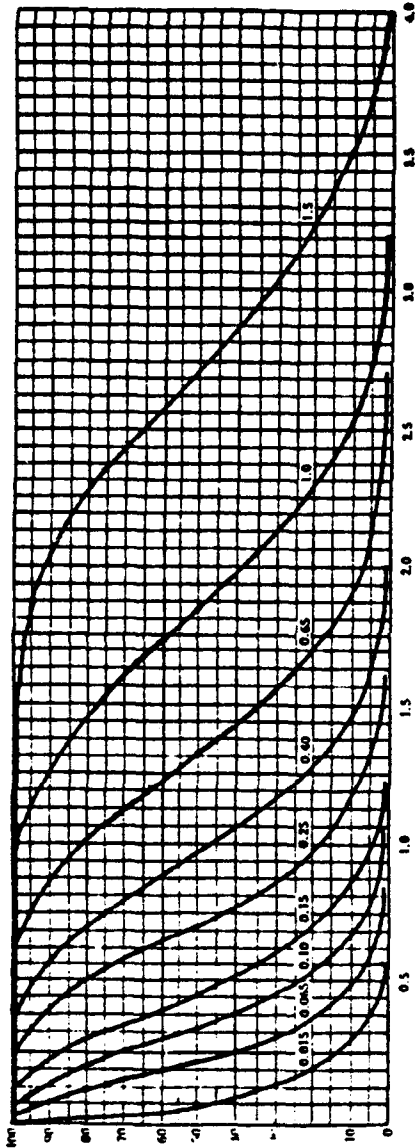
- △ = Use next preceding sample size code letter for which acceptance and rejection numbers are available.  
 ▽ = Use next subsequent sample size code letter for which acceptance and rejection numbers are available.  
 Ac = Acceptance number  
 Re = Rejection number  
 • = Use single sampling plan above (or alternatively use code letter R)  
 • = Acceptance not permitted at this sample size.

N



CHART P - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

(Curves for double and multiple sampling are matched as closely as practicable)

PERCENT OF LOTS  
ACCEPTED TO BE  
ACCEPTED ( $P_a$ )QUALITY OF SUBMITTED LOTS ( $p$  is percent defective for AQL's  $< 10$ ; in defects per hundred units for AQL's  $> 10$ )

Note: Figures on curves are Acceptable Quality Levels (AQL's) for normal inspection.

TABLE X-P-1 - TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

$P_a$	Acceptable Quality Levels (normal inspection)											
	0.015	0.025	0.040	0.065	0.10	0.15	0.25	0.40	0.65	1.0	1.5	2.0
p (in percent defective or defects per hundred units)												
99.0	0.00126	0.0186	0.0545	0.103	0.223	0.363	0.596	0.935	1.29	1.57		
95.0	0.00641	0.0444	0.102	0.171	0.327	0.498	0.587	0.771	0.961	1.16	1.56	1.86
90.0	0.0132	0.0665	0.138	0.218	0.394	0.582	0.679	0.878	1.08	1.29	1.71	2.03
75.0	0.0340	0.120	0.216	0.317	0.527	0.745	0.855	1.08	1.30	1.53	1.99	2.34
50.0	0.0866	0.210	0.334	0.459	0.709	0.959	1.08	1.33	1.58	1.83	2.33	2.71
25.0	0.173	0.337	0.490	0.639	0.928	1.21	1.35	1.63	1.90	2.17	2.72	3.12
10.0	0.288	0.486	0.665	0.835	1.16	1.47	1.62	1.93	2.22	2.52	3.09	3.52
5.0	0.374	0.593	0.787	0.969	1.31	1.64	1.80	2.12	2.43	2.74	3.34	3.78
1.0	0.576	0.840	1.05	1.26	1.64	2.00	2.18	2.52	2.85	3.18	3.82	4.29
0.015	0.10	0.15	0.25	0.40	0.65	1.0	1.5	2.0	2.5	3.0	3.5	4.0
Acceptable Quality Levels (tightened inspection)												

Note: All values given in above table based on Poisson distribution as an approximation to the binomial.

TABLE X-P-2 - SAMPLING PLANS FOR SAMPLE SIZE CODE LETTER: P

Type of sampling plan	Cumulative sample size	Acceptable Quality Levels (normal inspection)																		Cumulative sample size
		0.010	0.015	0.025	0.040	0.065	0.10	0.15	0.25	0.40	0.65	1.0	1.5	1.5	Higher than 1.5					
		Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re			
		Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re			
Single	800	▽	0	1															800	
Double	500	▽																	500	
	1000																		1000	
Multiple	200	▽																	200	
	400																		400	
	600																		600	
	800																		800	
	1000																		1000	
	1200																		1200	
	1400																		1400	
	Less than 0.025	0.025	0.040	0.065	0.10	0.15	0.25	0.40	0.65	1.0	1.5	1.5	1.5	Higher than 1.5						
Acceptable Quality Levels (tightened inspection)																				

△ = Use next preceding sample size code letter for which acceptance and rejection numbers are available.

▽ = Use next subsequent sample size code letter for which acceptance and rejection numbers are available.

Ac = Acceptance number.

Re = Rejection number.

• = Use single sampling plan above.

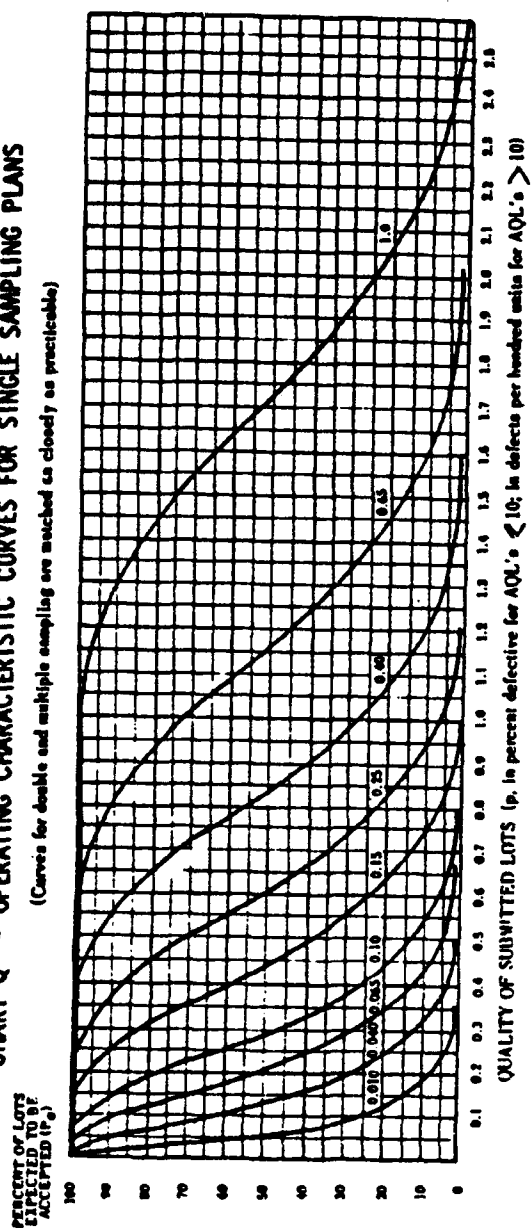
• = Acceptance not permitted at this sample size.

P

TABLE X-Q—Tables for sample size code letter: Q

CHART Q - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

(Curves for double and multiple sampling are matched as closely as practicable)



Note: Figures on curves are Acceptable Quality Levels (AQL's) for normal inspection

TABLE X-Q-1 - TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

Pa	Acceptable Quality Levels (normal inspection)											
	0.010	0.040	0.065	0.10	0.15	0.25	0.40	0.65	1.0	1.5	2.0	2.5
	p (in percent defective or defects per hundred units)											
99.0	0.000804	0.0119	0.0340	0.0658	0.143	0.232	0.281	0.382	0.488	0.598	0.828	1.01
95.0	0.00410	0.0284	0.0654	0.109	0.209	0.318	0.376	0.494	0.615	0.740	0.995	1.19
90.0	0.00843	0.0425	0.0882	0.140	0.252	0.372	0.435	0.562	0.692	0.824	1.09	1.39
75.0	0.0230	0.0769	0.138	0.203	0.308	0.476	0.547	0.690	0.834	0.979	1.27	1.49
50.0	0.0555	0.134	0.214	0.294	0.454	0.614	0.694	0.853	1.01	1.17	1.49	1.73
25.0	0.111	0.215	0.314	0.409	0.594	0.775	0.864	1.04	1.22	1.39	1.74	2.00
10.0	0.184	0.311	0.426	0.534	0.742	0.942	1.04	1.23	1.42	1.61	1.98	2.25
5.0	0.240	0.380	0.504	0.620	0.841	1.05	1.15	1.36	1.56	1.75	2.14	2.42
1.0	0.348	0.531	0.672	0.804	1.05	1.28	1.39	1.61	1.83	2.04	2.45	2.75
0.015	0.065	0.10	0.15	0.25	0.40	0.65	1.0	1.5	2.0	2.5	3.0	3.5

Note: All values given in above table based on Poisson distribution as an approximation to the Binomial

TABLE X-Q-2 - SAMPLING PLANS FOR SAMPLE SIZE CODE LETTER: Q

MIL-STD-105B

Type of sampling plan	Cumulative sample size	Acceptable Quality Levels (normal inspection)																								Cumulative sample size																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																													
		X	0.010		0.015		X		0.025		0.040		0.065		0.10		0.15		0.25		X		0.40		X		0.65		X		1.0		Higher than 1.0																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																						
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Δ = Use next preceding sample size code letter for which acceptance and rejection numbers are available.

Ac = Acceptance number

Re = Rejection number

• = Use single sampling plan above.

• = Acceptance not permitted at this sample size.

TABLE X-R—Tables for sample size code letter: R

CHART R - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

(Curves for double and multiple sampling are matched as closely as practicable)

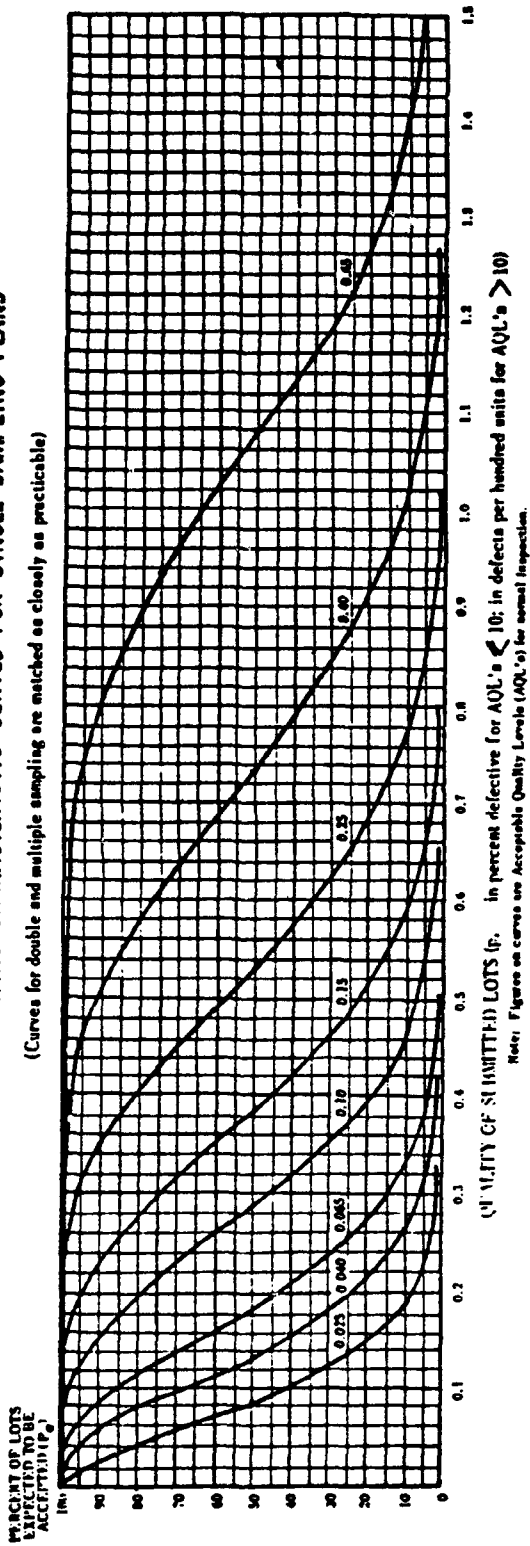


TABLE X-R-1 - TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

P <sub>d</sub>	Acceptable Quality Levels (normal inspection)										
	0.025	0.040	0.065	0.10	0.15	0.25	0.40	0.65			
	p (in percent defective or defects per hundred units)										
99.0	0.00743	0.0218	0.0412	0.0892	0.145	0.175	0.239	0.305	0.374	0.517	0.659
95.0	0.0178	0.0409	0.0683	0.131	0.199	0.235	0.309	0.394	0.462	0.622	0.745
90.0	0.0266	0.0551	0.0872	0.158	0.233	0.272	0.351	0.432	0.515	0.684	0.812
75.0	0.0481	0.0864	0.127	0.211	0.298	0.342	0.431	0.521	0.612	0.795	0.934
50.0	0.0839	0.134	0.181	0.284	0.383	0.433	0.533	0.633	0.733	0.933	1.08
25.0	0.115	0.196	0.255	0.371	0.484	0.540	0.651	0.761	0.870	1.09	1.25
10.0	0.184	0.266	0.334	0.464	0.589	0.650	0.770	0.889	1.01	1.24	1.41
5.0	0.237	0.315	0.388	0.526	0.657	0.722	0.849	0.972	1.09	1.33	1.51
1.0	0.332	0.420	0.502	0.655	0.800	0.870	1.02	1.14	1.27	1.53	1.72
	0.040	0.065	0.10	0.15	0.25	0.40	0.65	1.0	1.5	2.0	2.5
	Acceptable Quality Levels (tightened inspection)										

Note: All values given in above table based on Poisson distribution as an approximation to the Binomial.

$\Delta$	■	Use next preceding sample size code letter for which acceptance and rejection numbers are available.
Ac	■	Acceptance number.
Re	■	Rejection number.
o	■	Use single sampling plan above.
e	■	Acceptance not permitted at this sample size.

TABLE X-S—Tables for sample size code letter: S

MIL-STD-105B

Type of sampling plan	Cumulative sample size	Acceptable Quality Level (normal inspection)	
		Ac	Re
Single	3150	1	2
Double	2000	0	2
	4000	1	2
Multiple	800	0	2
	1600	0	2
	2400	0	2
	3200	0	3
	4000	1	3
	4800		3
	5600		3
		0.025	
		Acceptable Quality Level (tightened inspection)	

Ac = Acceptance number

Re = Rejection number

0 = Acceptance not permitted at this sample size.

6. NOTES

6.1 Intended Use. Sampling procedures and tables for inspection by attributes are intended to be used in the acquisition of Defense material.

6.2 Subject Term (Key Word) Listing.

Acceptable Quality Level (AQL)

Average Outgoing Quality (AOQ)

Defect

Defective

Lot or Batch

Process Average

Sample

Sampling Plan

Unit of Product

6.3 Changes from Previous Issue. Vertical lines or asterisks are not used in this revision to identify changes with respect to the previous issue due to the extensiveness of the changes.



MIL-STD-105E

CONCLUDING MATERIAL

Custodians:

Army - AR  
Navy - OS  
Air Force - 23

Preparing Activity:

Army - AR

Review Activities:

Army - MI, EA, TE, AV, ER  
Navy - AS, EC, MC, OM, SA,  
SH, TD, YD  
DLA - ES, GS, SS  
OSD - IP, SO

(Project QCIC-0085)

User Activities:

Army - ME  
DLA - ES, SS

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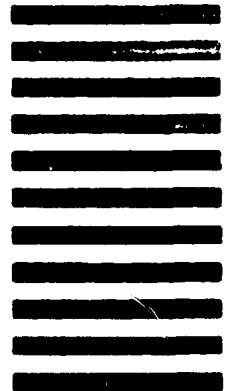
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